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(54) **NESTED BLOW MOLDED LINER AND OVERPACK AND METHODS OF MAKING SAME**

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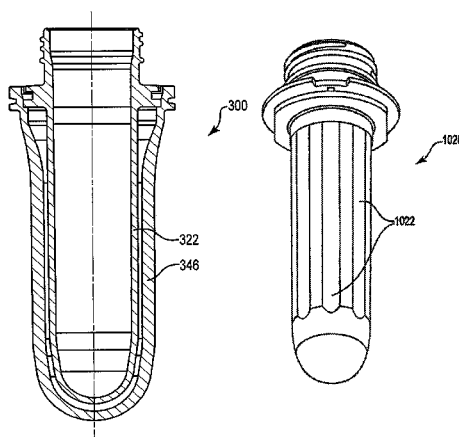
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#### **ABSTRACT**

The present disclosure relates to an integrated liner-based system having an overpack and a liner provided within the overpack, the liner comprising a mouth and a liner wall forming an interior cavity of the liner and having a thickness such that the liner is substantially self-supporting in an expanded state, but is collapsible at a pressure of less than about 20 psi. The liner and overpack may be made by blow molding the liner and the overpack at the same time using nested preforms.

**17 Claims, 36 Drawing Sheets**



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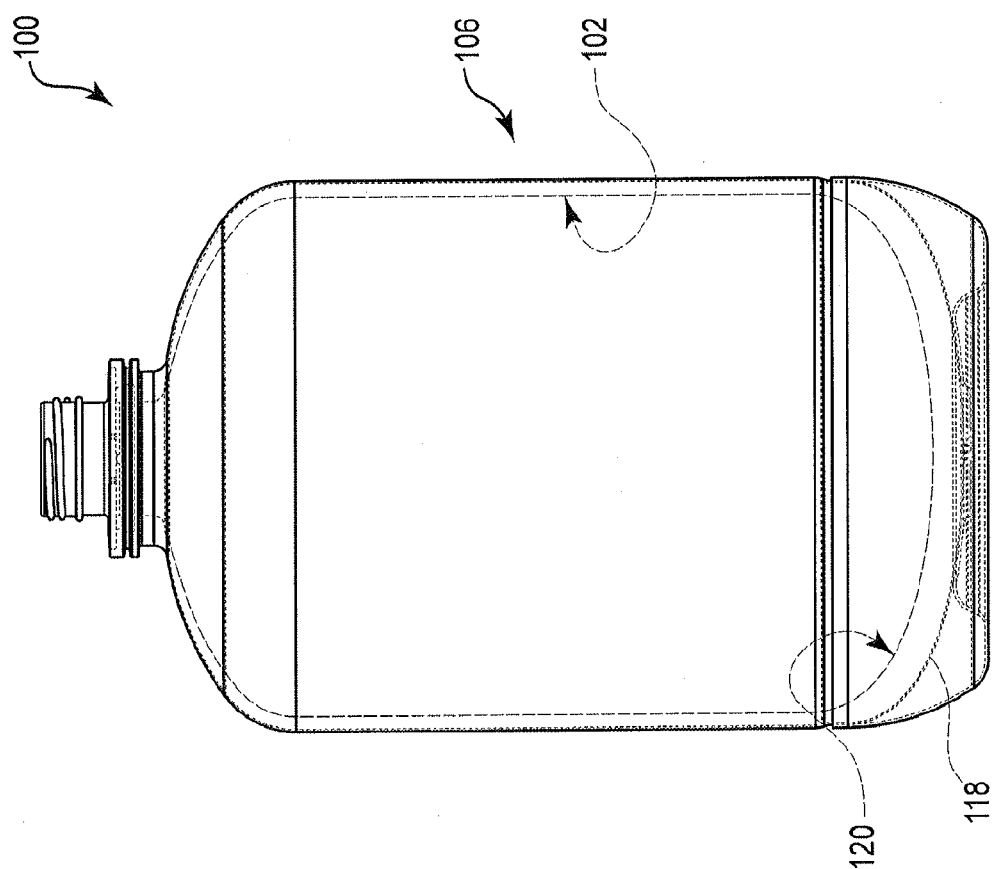


Fig. 1A

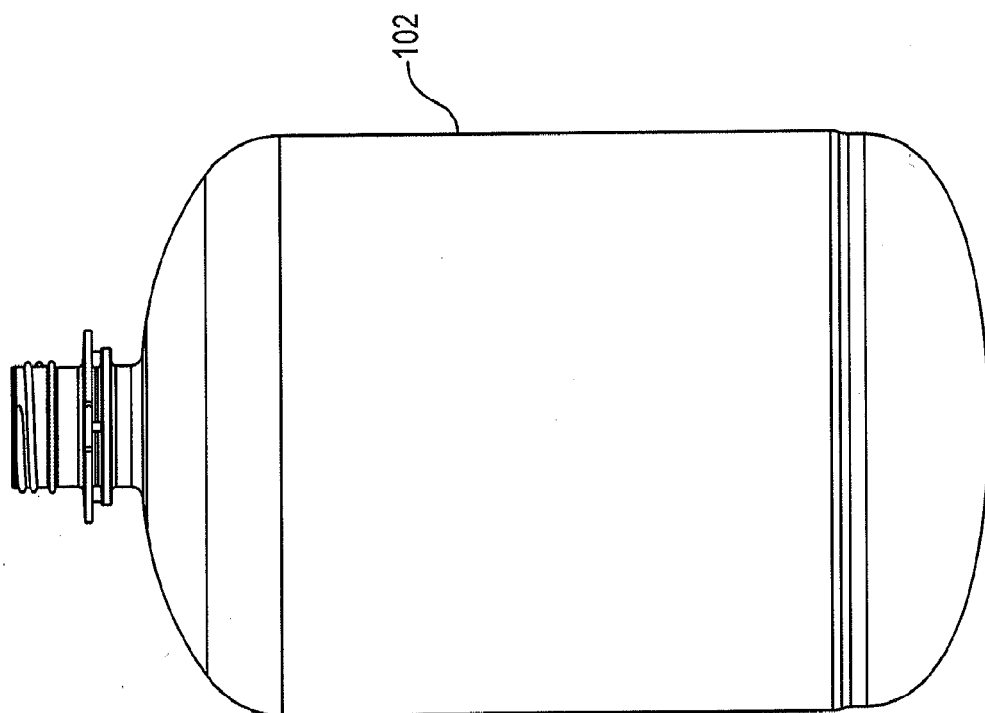


Fig. 1B

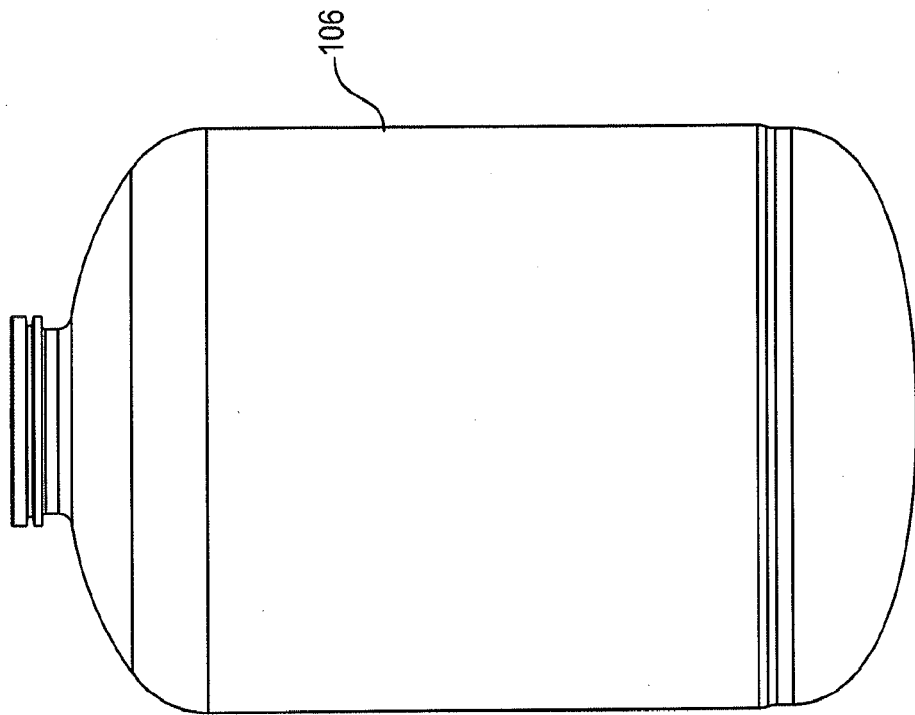


Fig. 1C

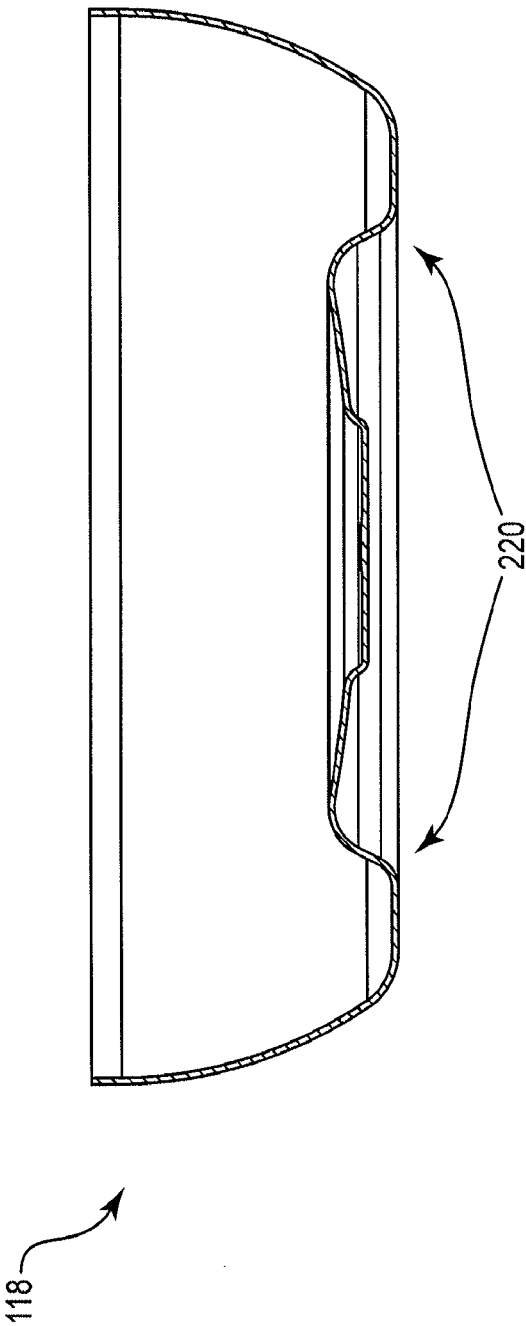
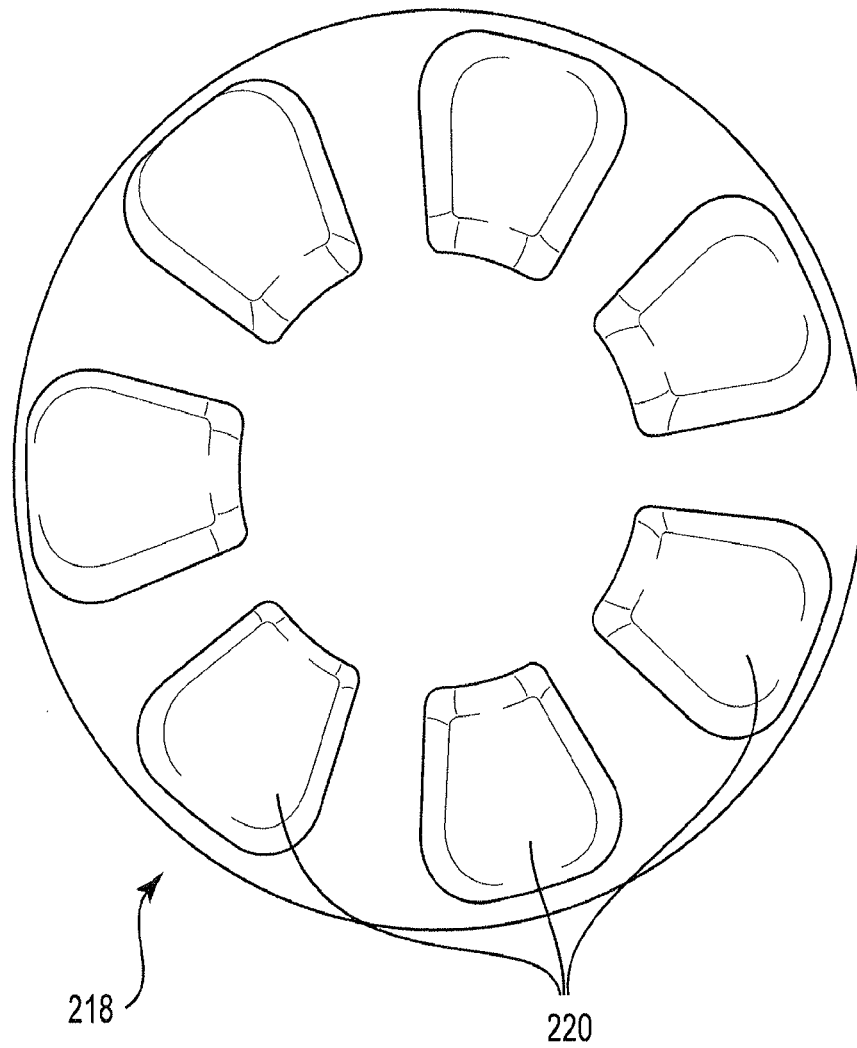


Fig. 2A





**Fig.2B**

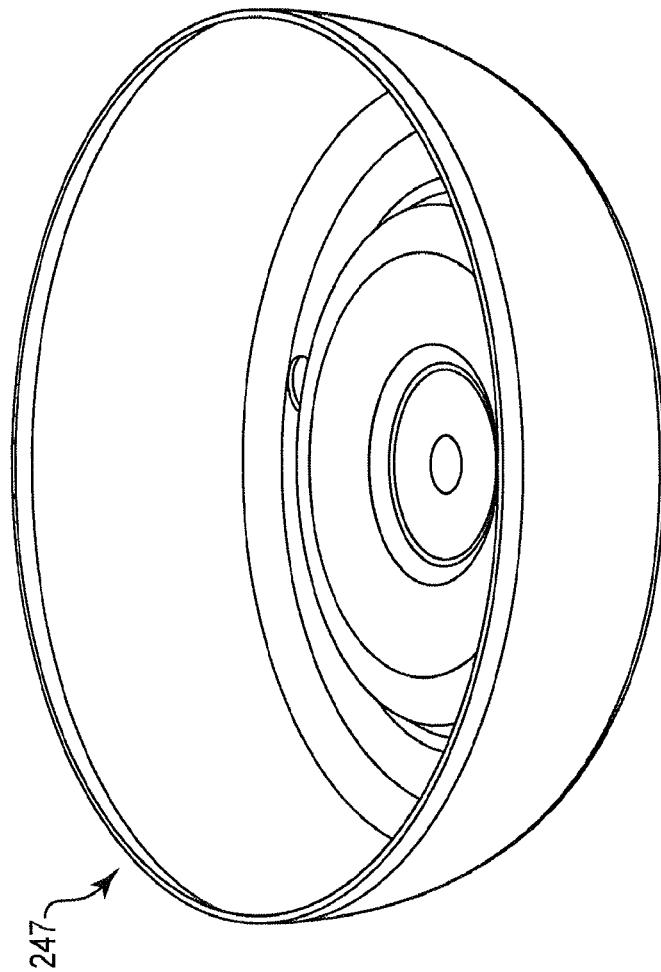


Fig. 2C

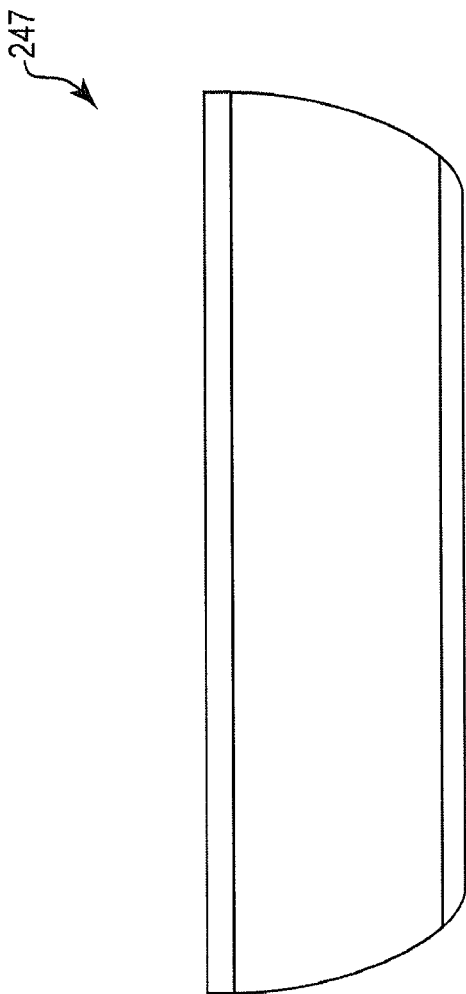


Fig. 2D

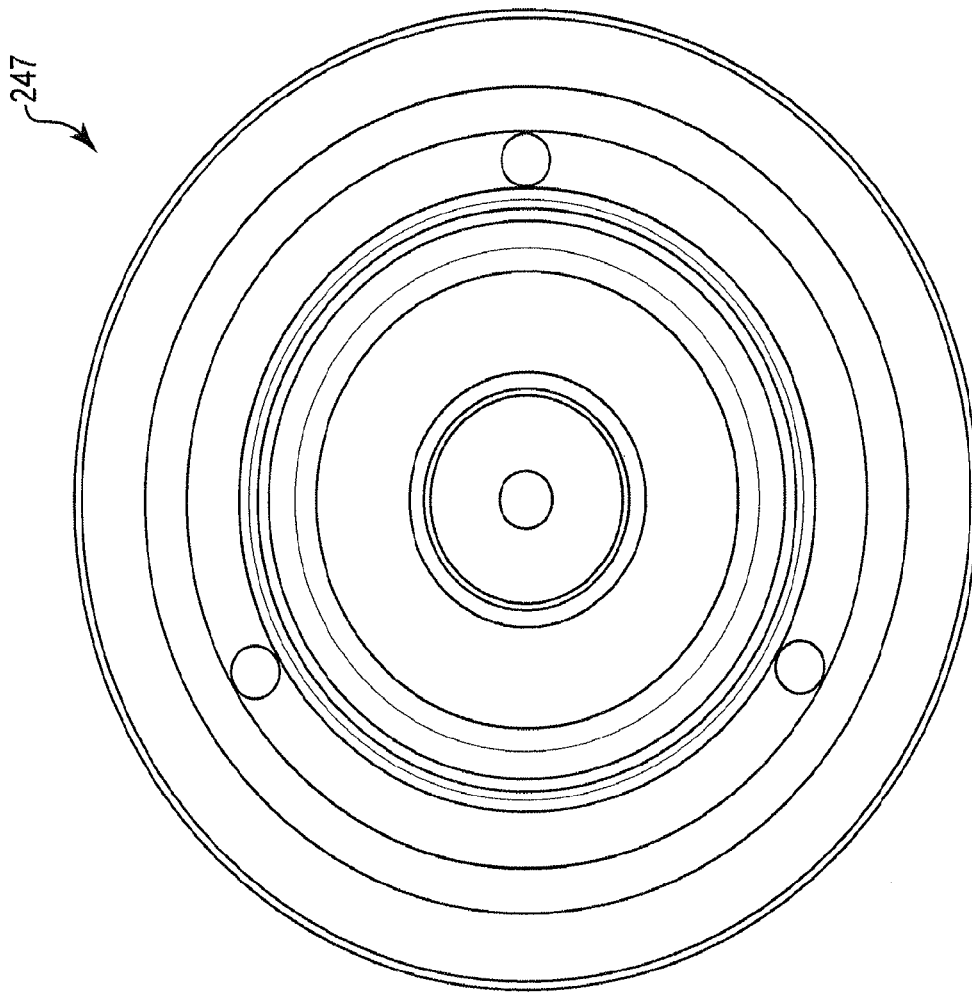


Fig. 2E

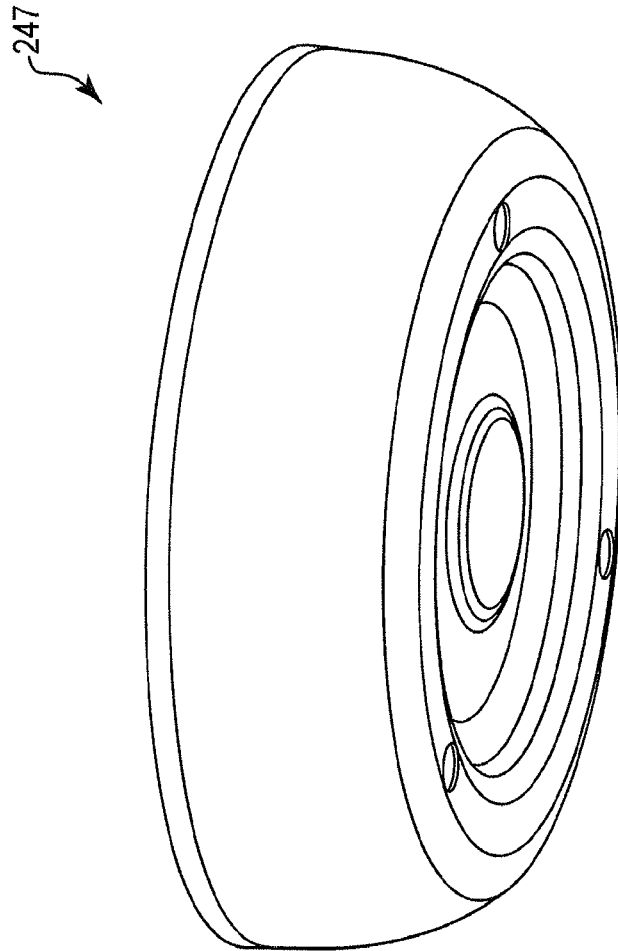


Fig. 2F

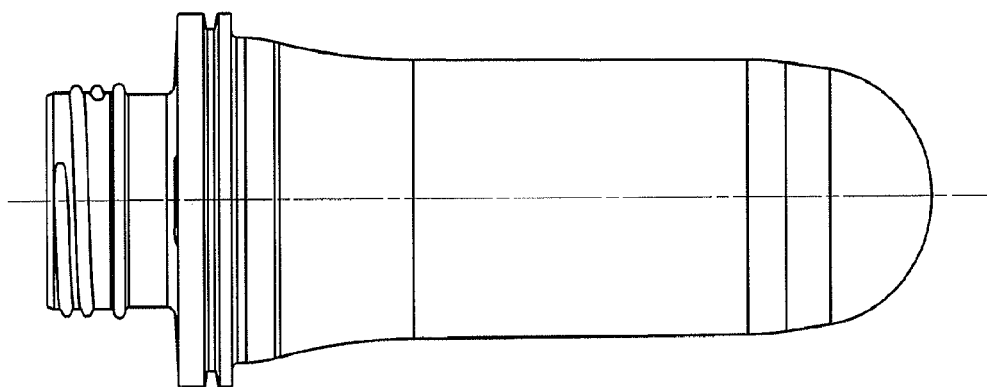


Fig. 3B

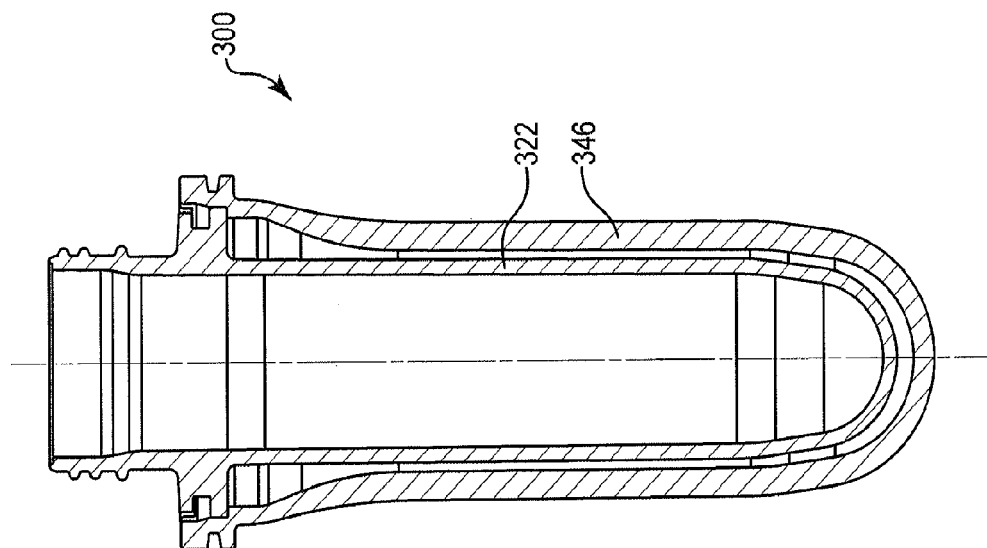


Fig. 3A

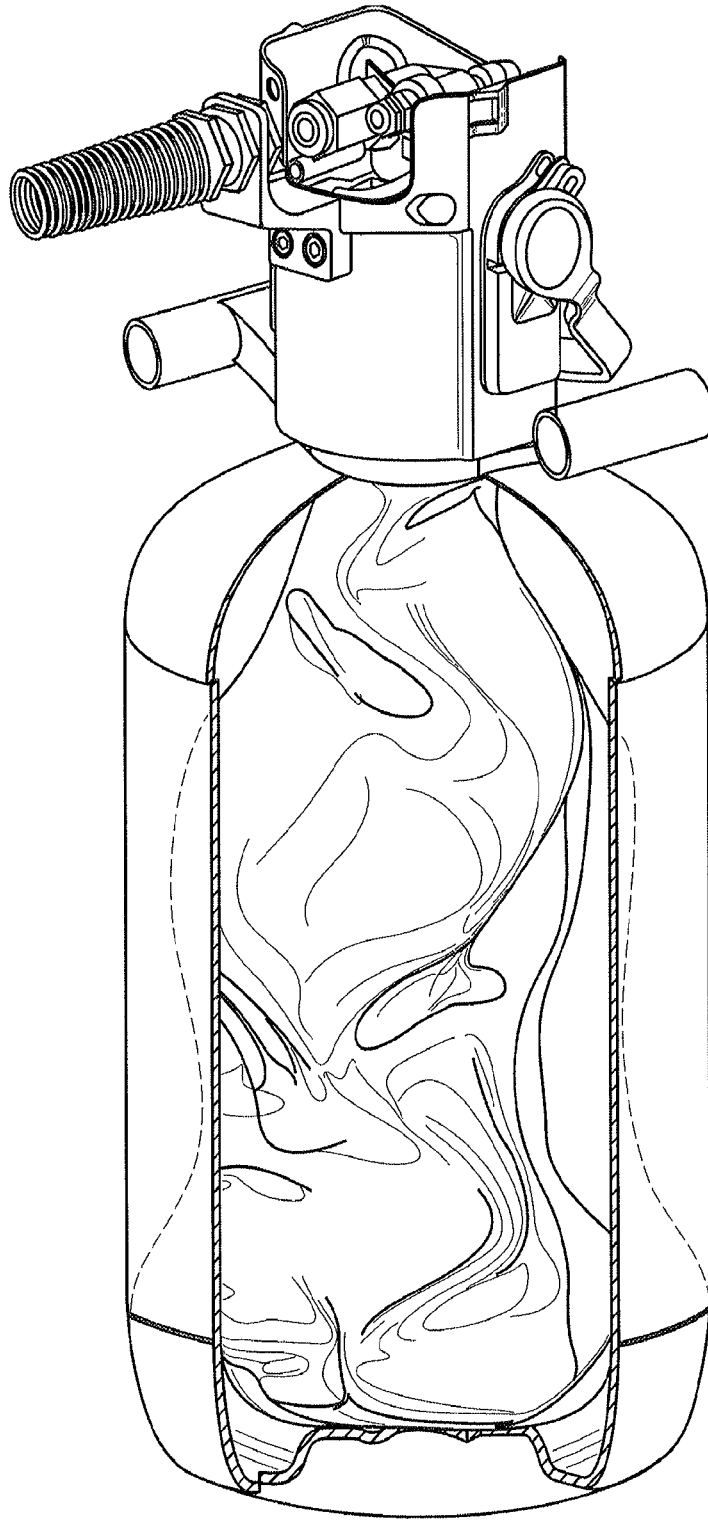


Fig. 4

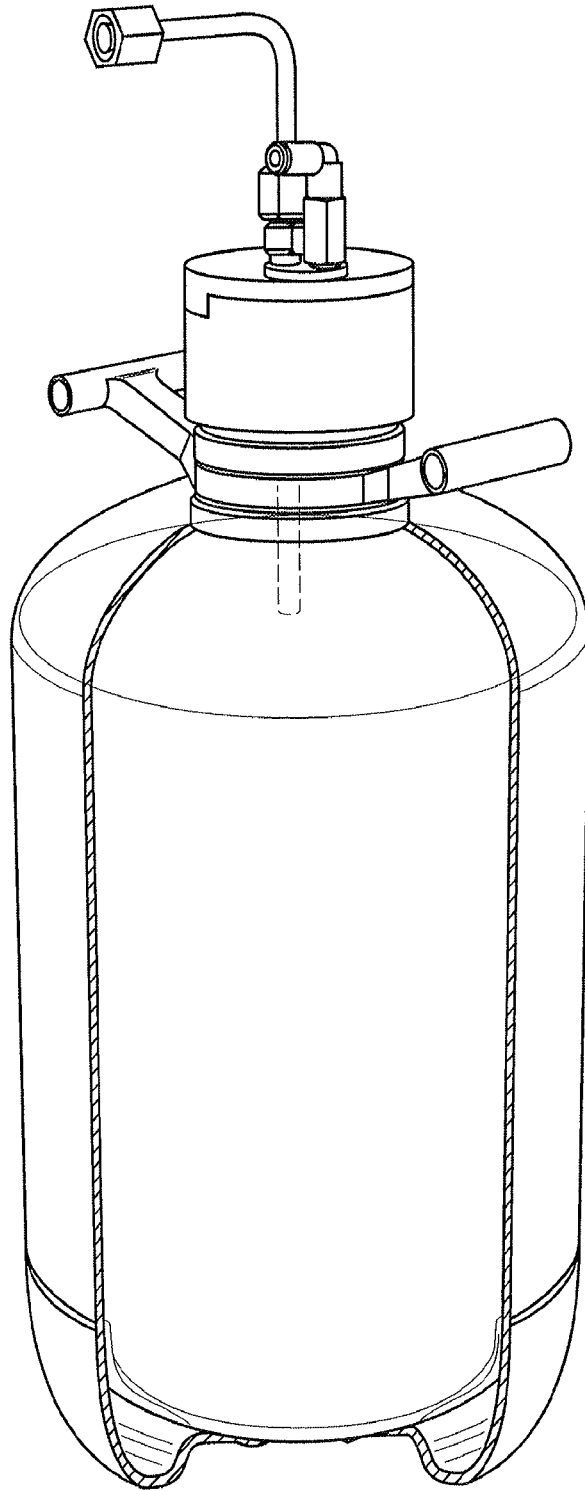


Fig. 5A



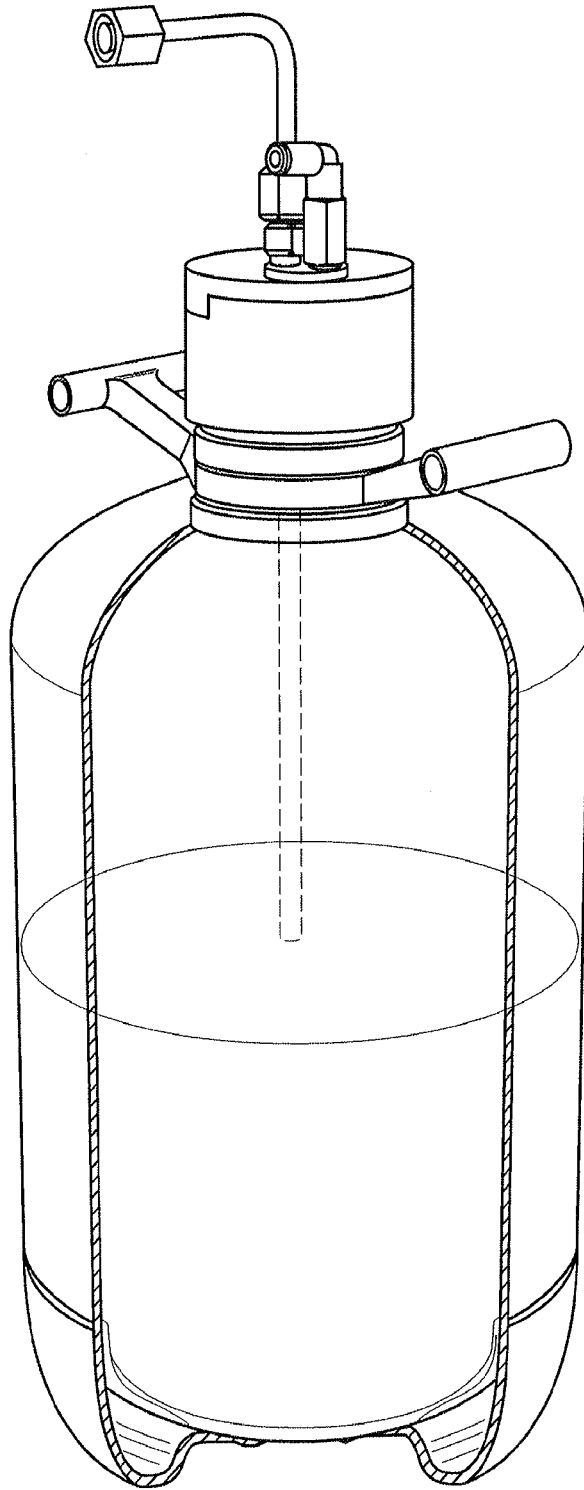


Fig. 5B

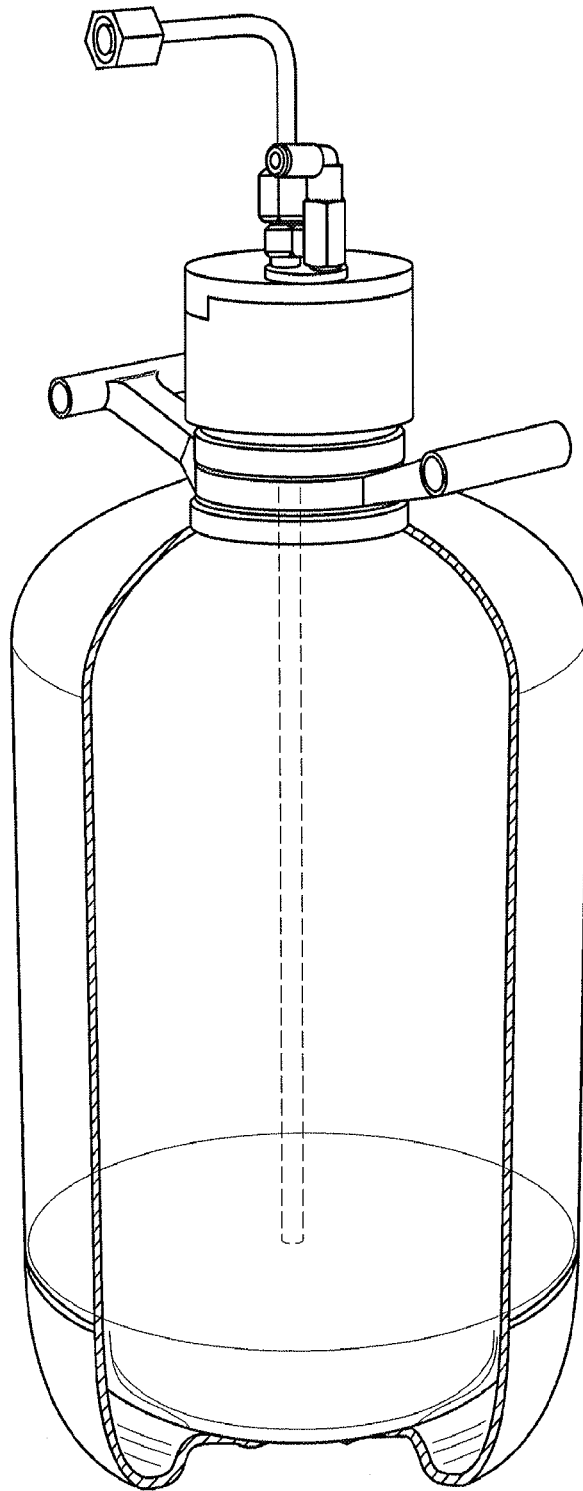


Fig. 5C

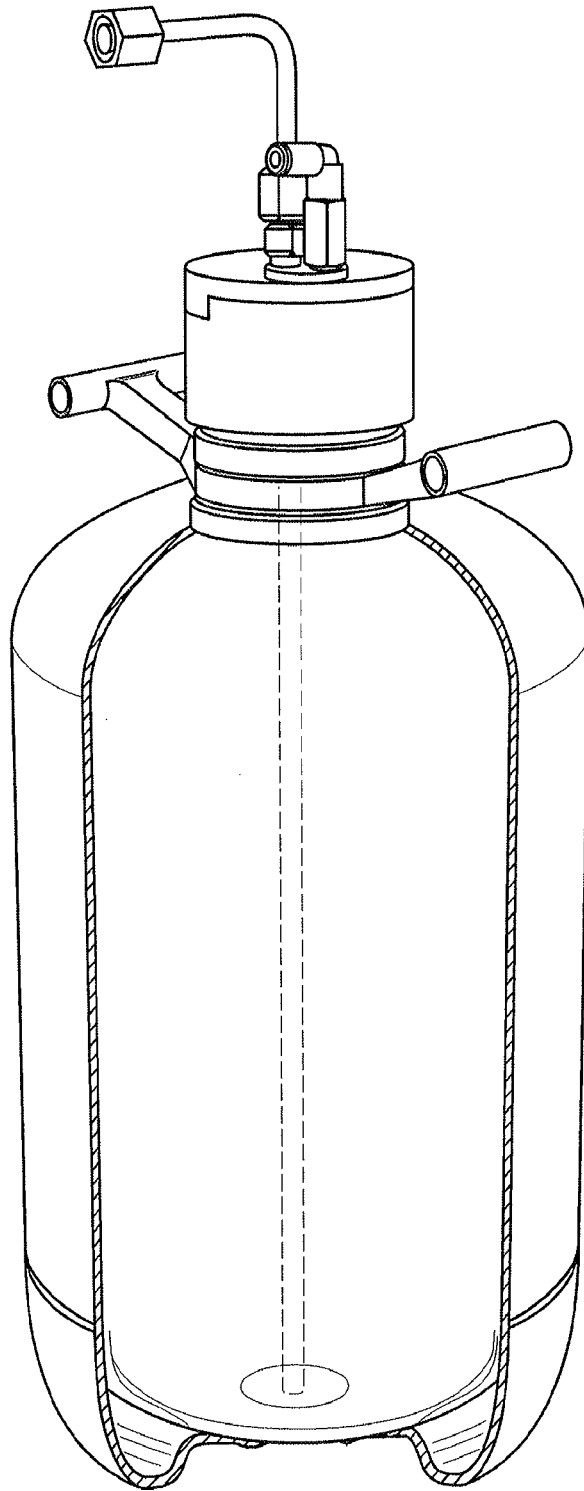


Fig. 5D

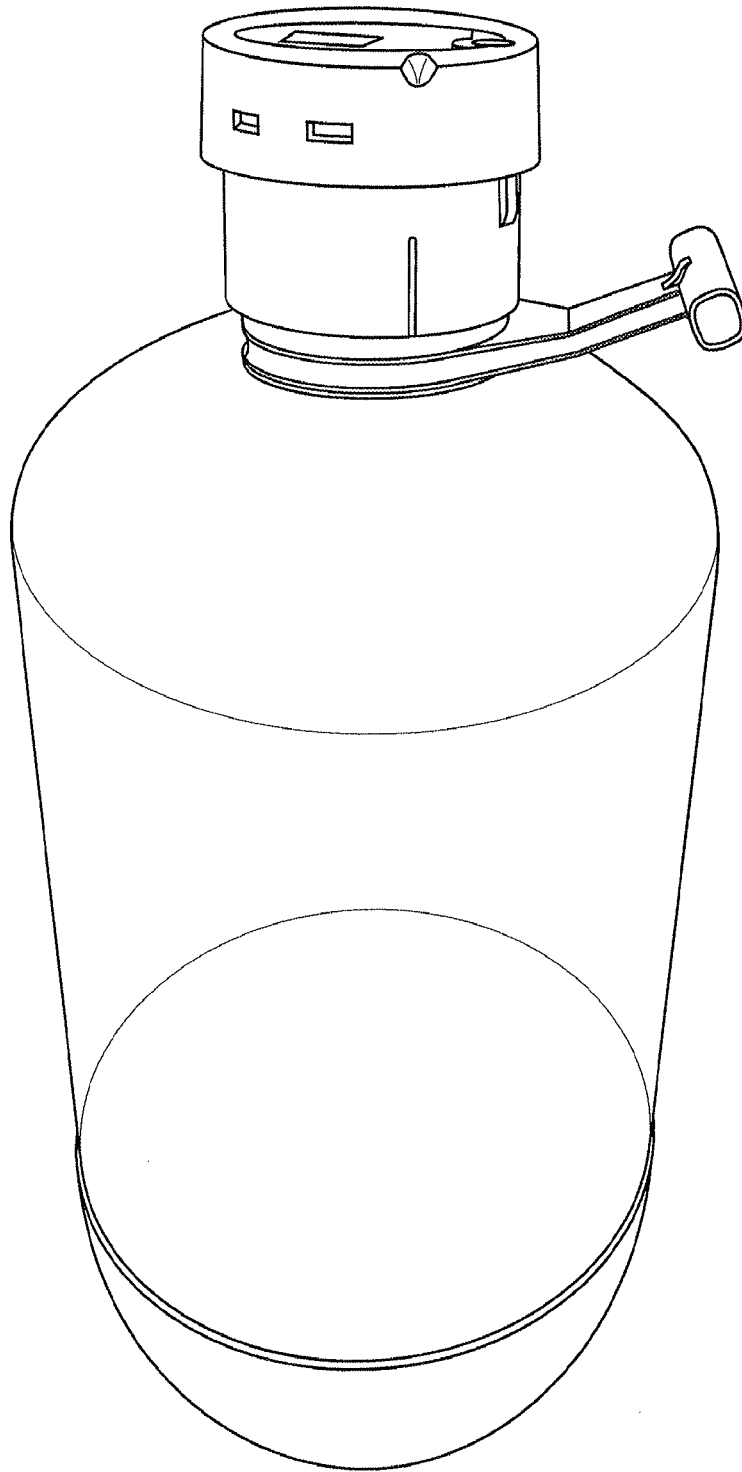
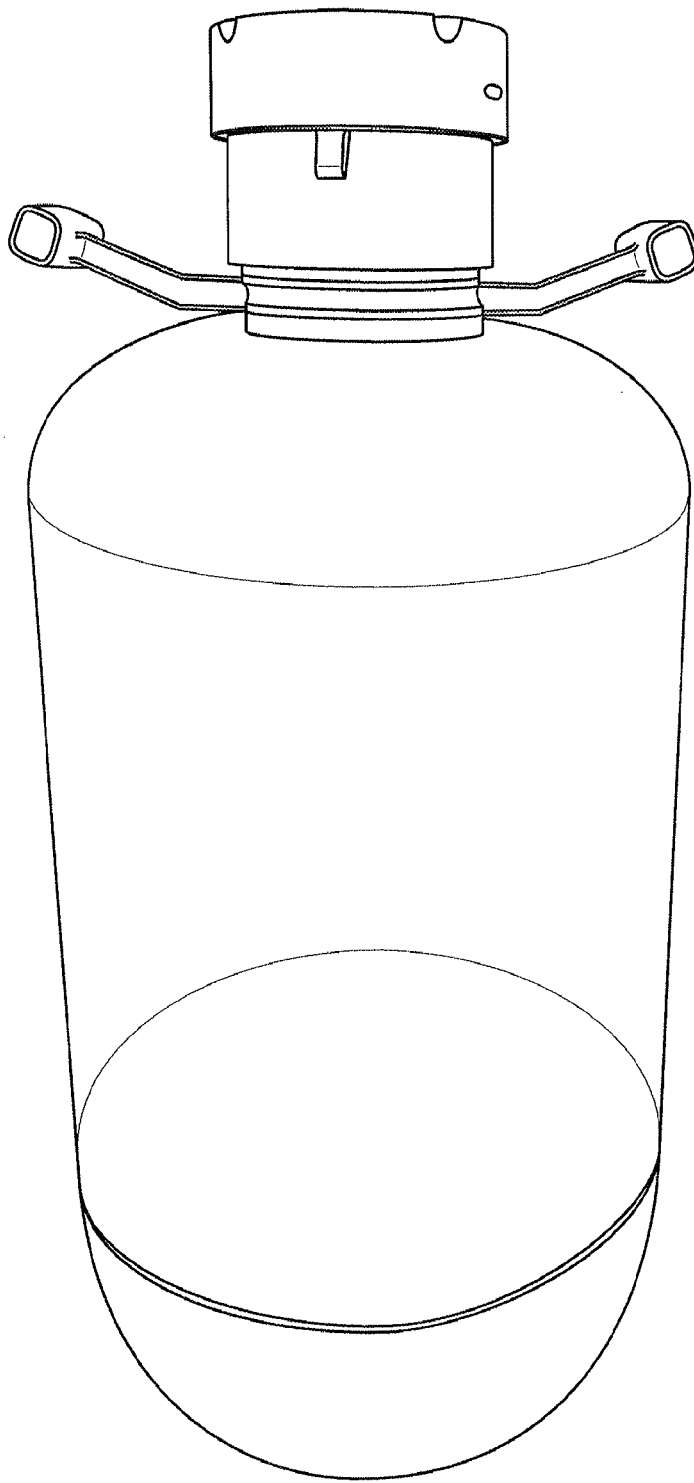
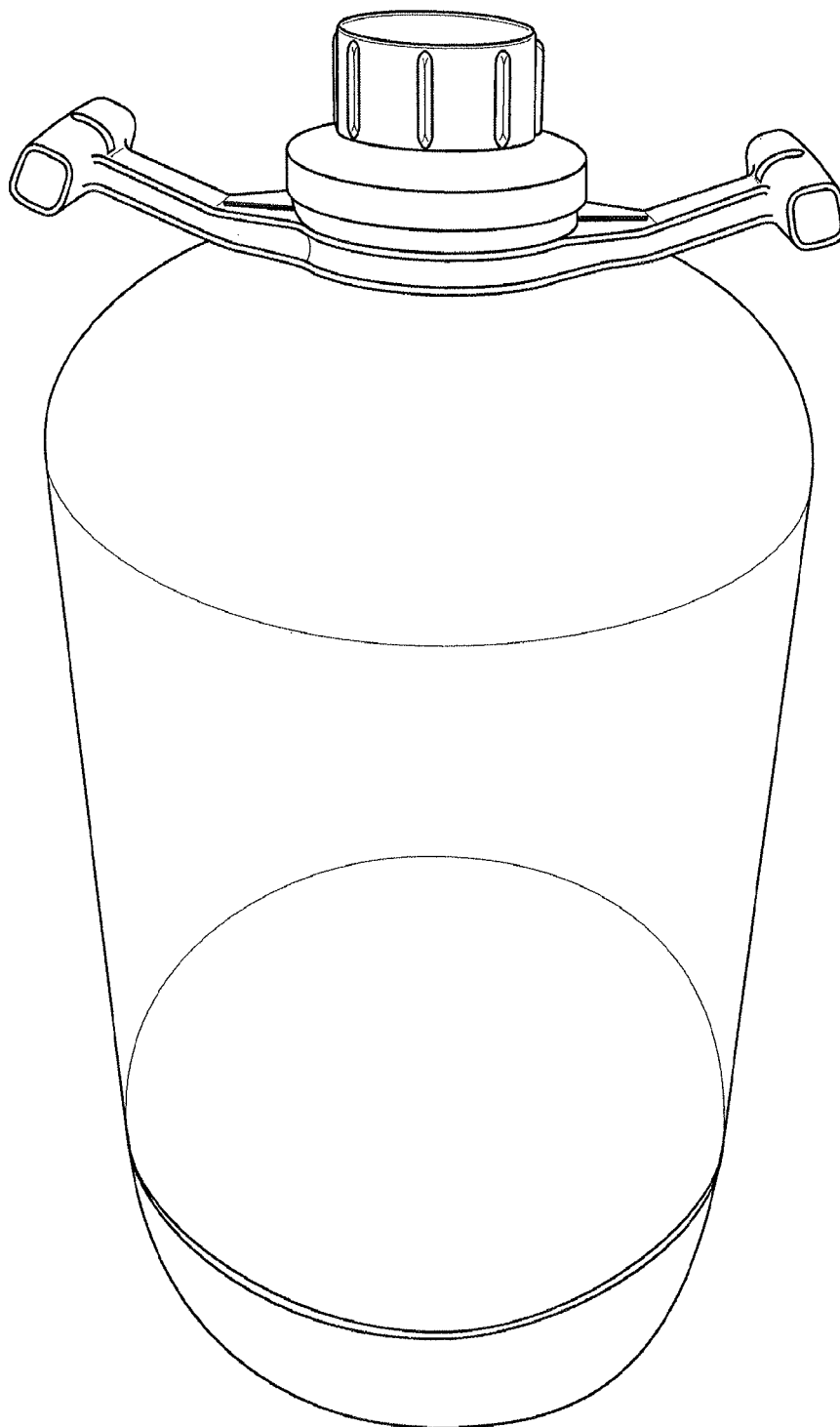


Fig. 6A



**Fig. 6B**



**Fig. 6C**

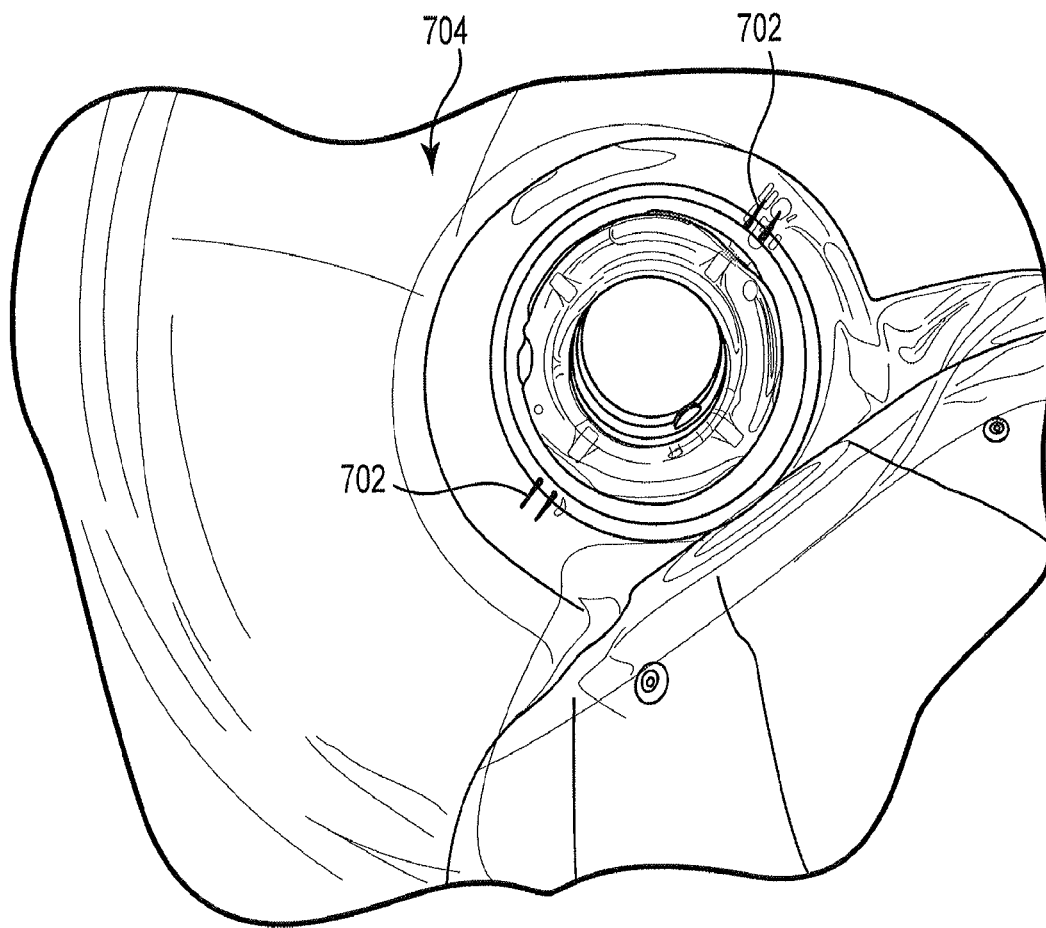


Fig. 7A

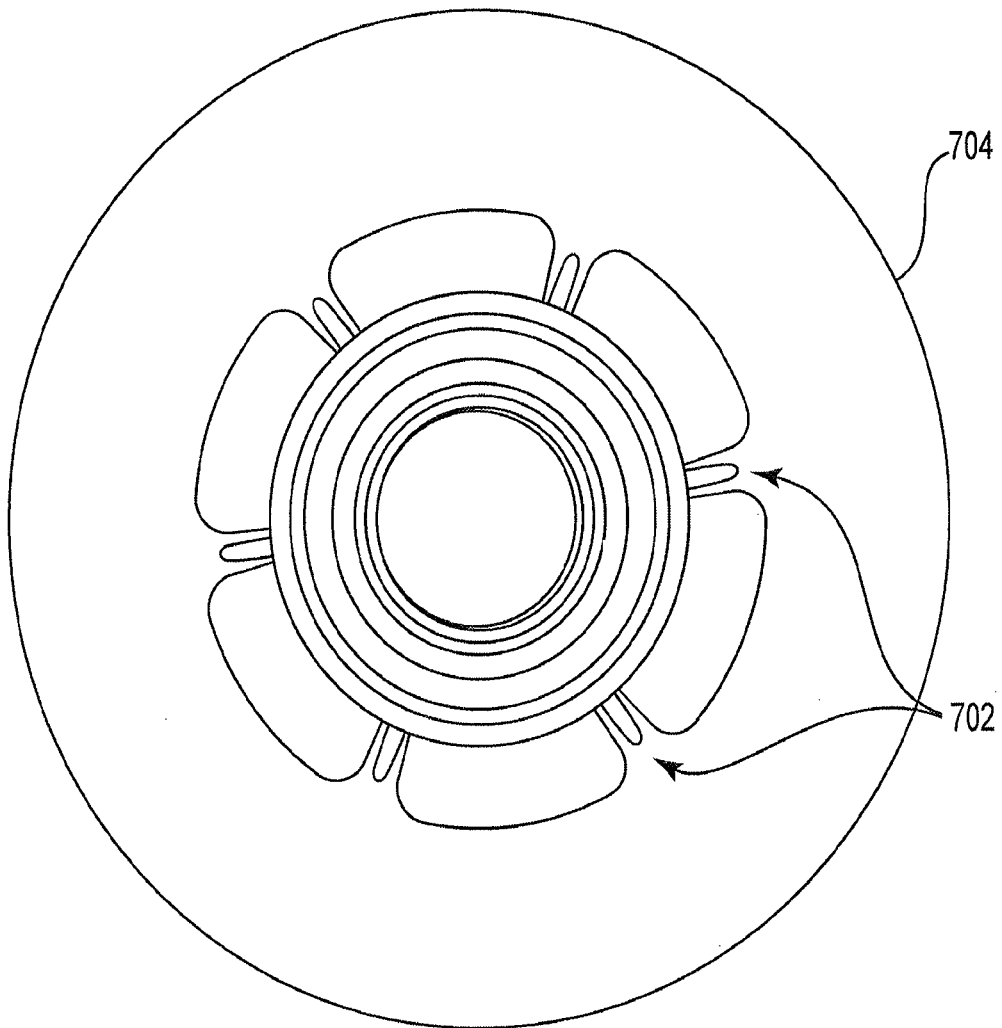
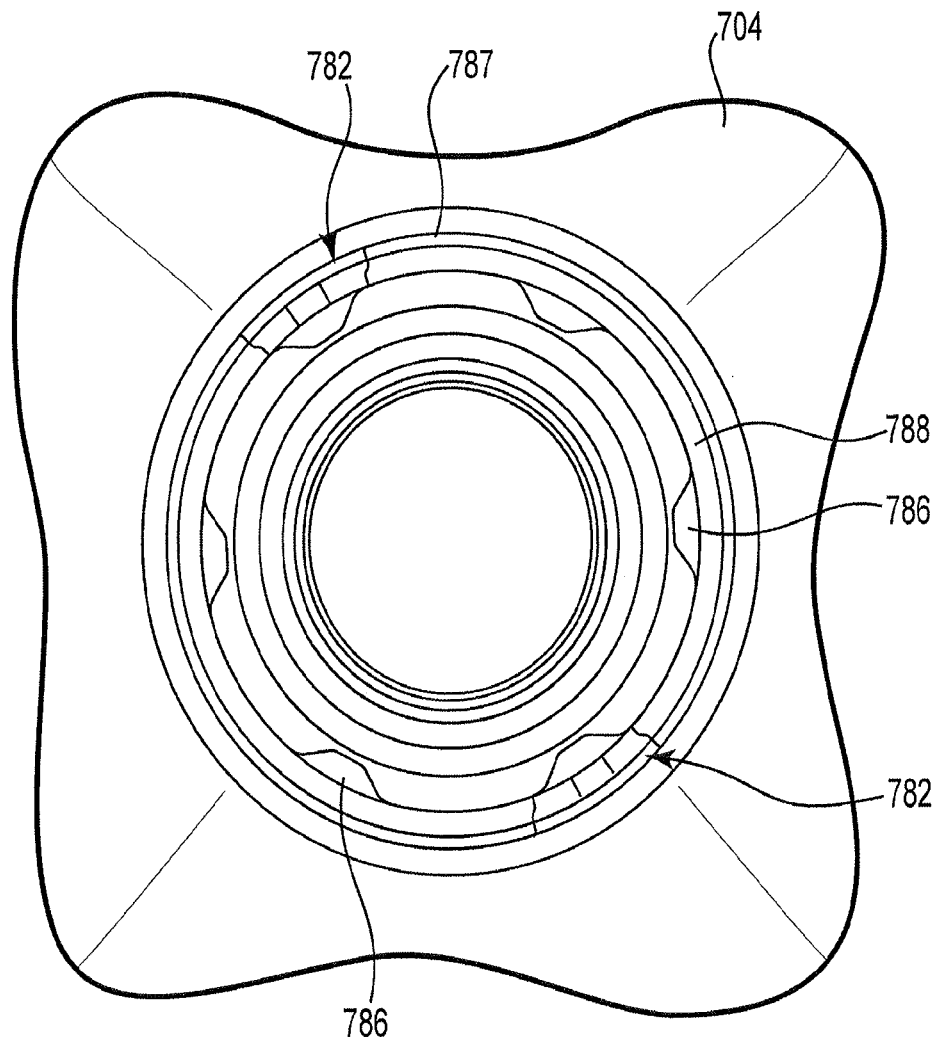
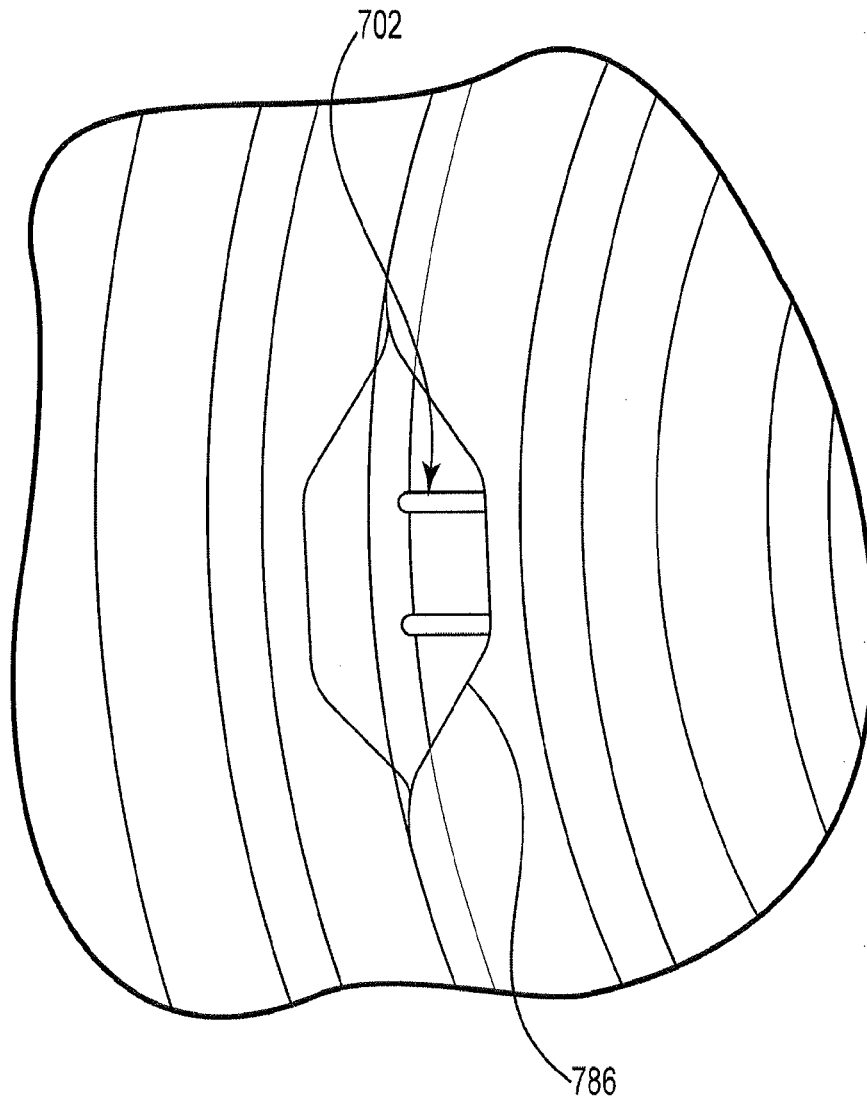


Fig. 7B





**Fig. 7C**



**Fig. 7D**

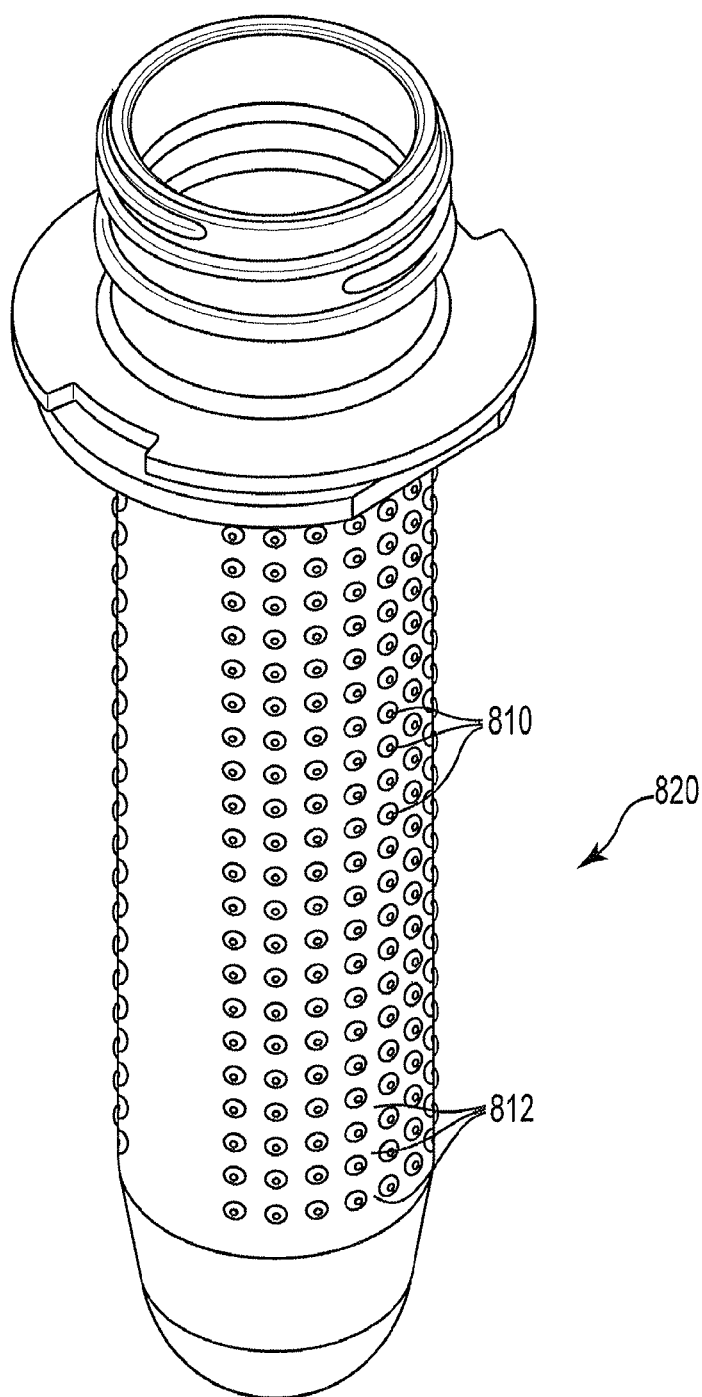


Fig. 8

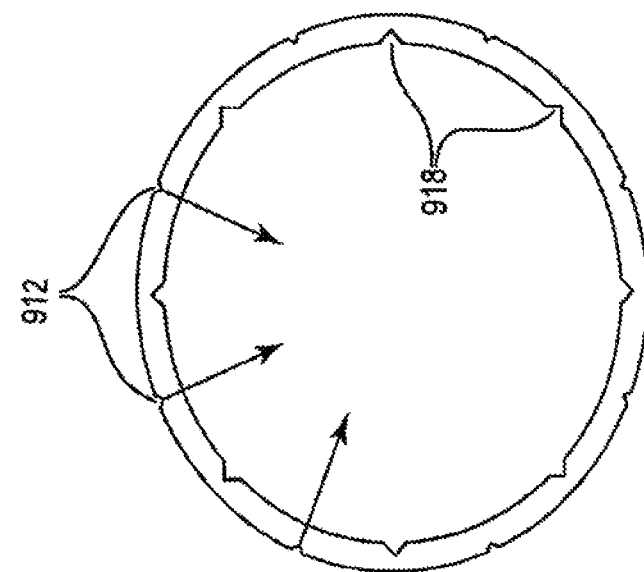


Fig. 9B

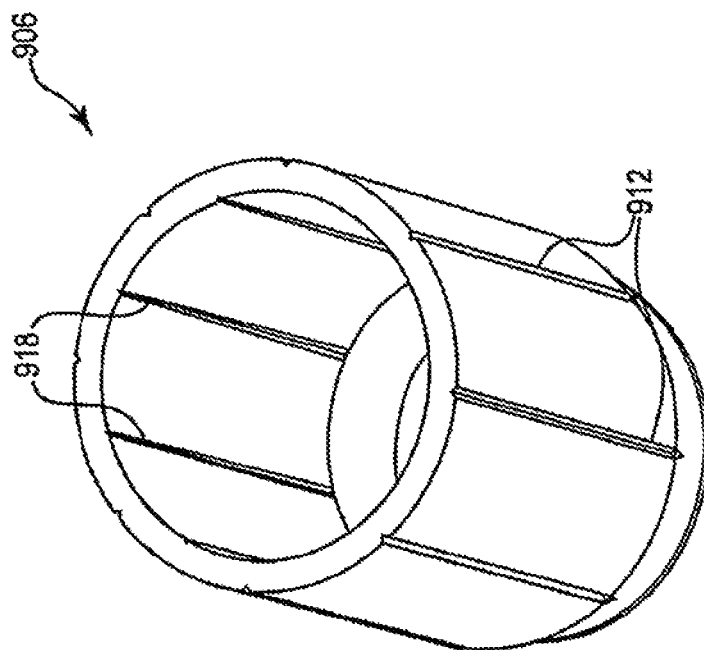


Fig. 9A

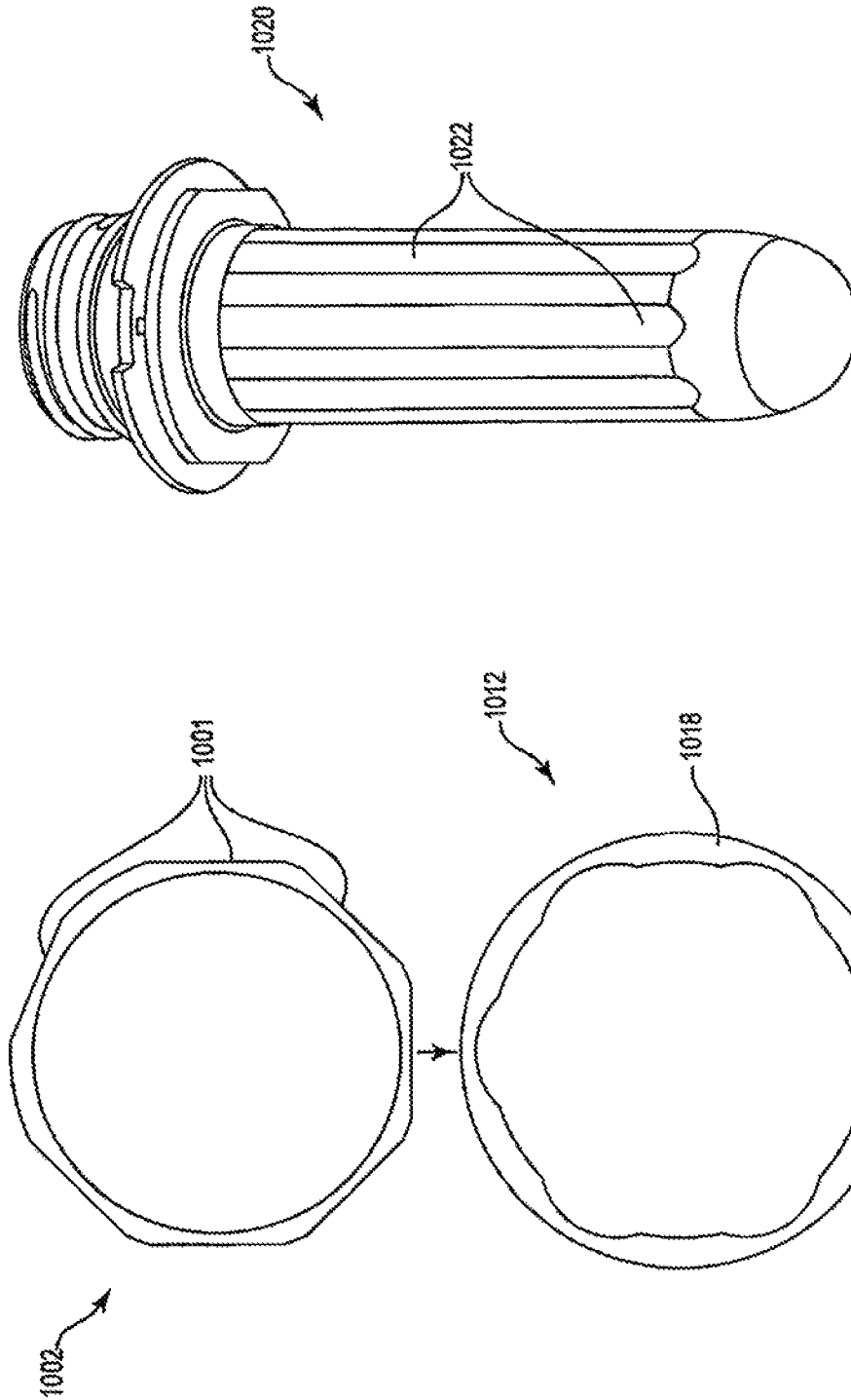


Fig. 10B

Fig. 10A

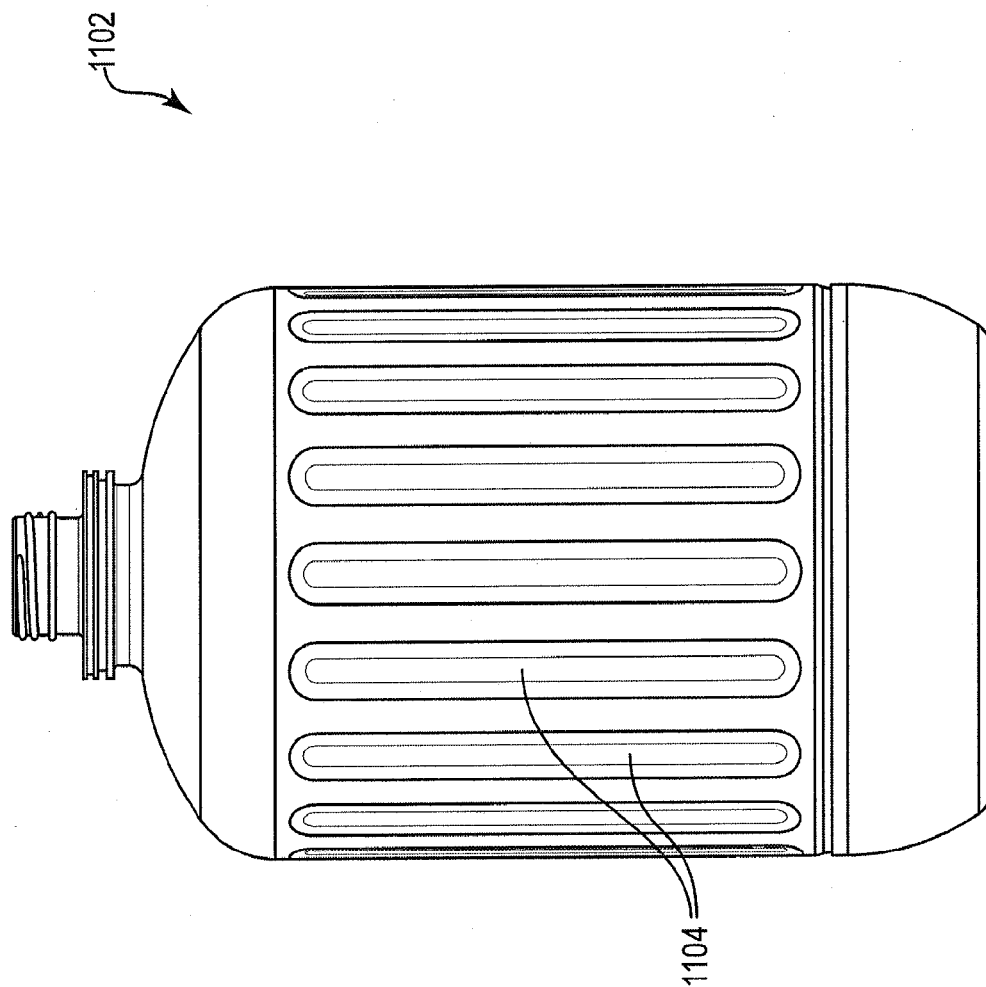


Fig. 11A

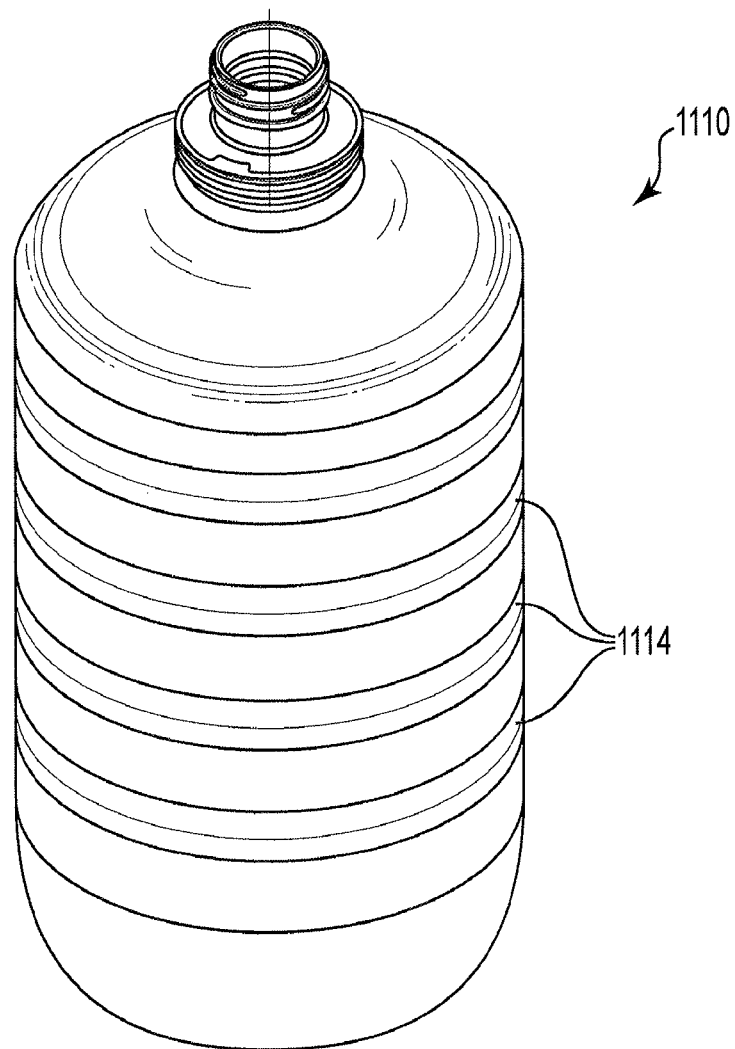
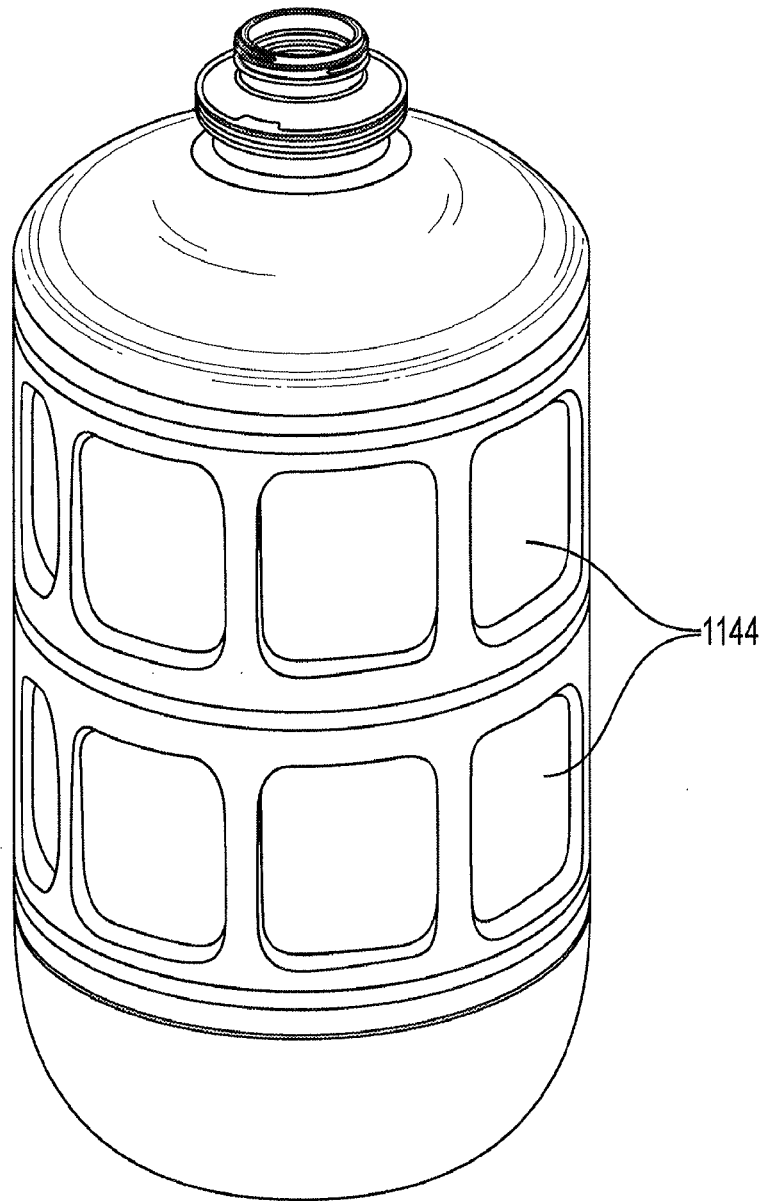


Fig. 11B



**Fig. 11C**



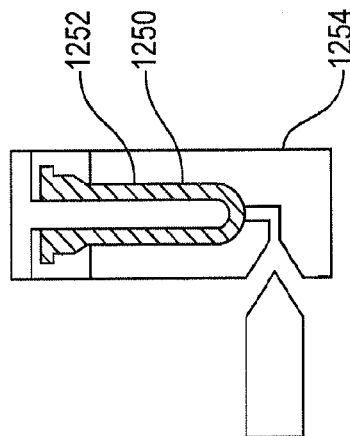


Fig. 12A

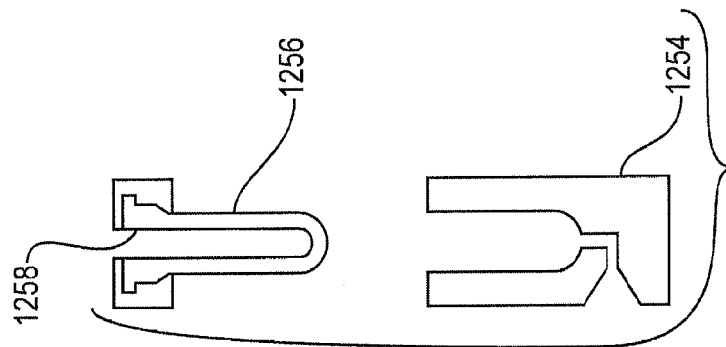


Fig. 12B

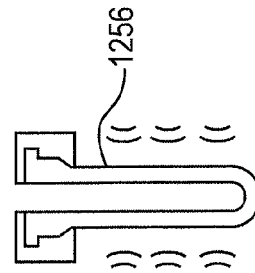


Fig. 12C

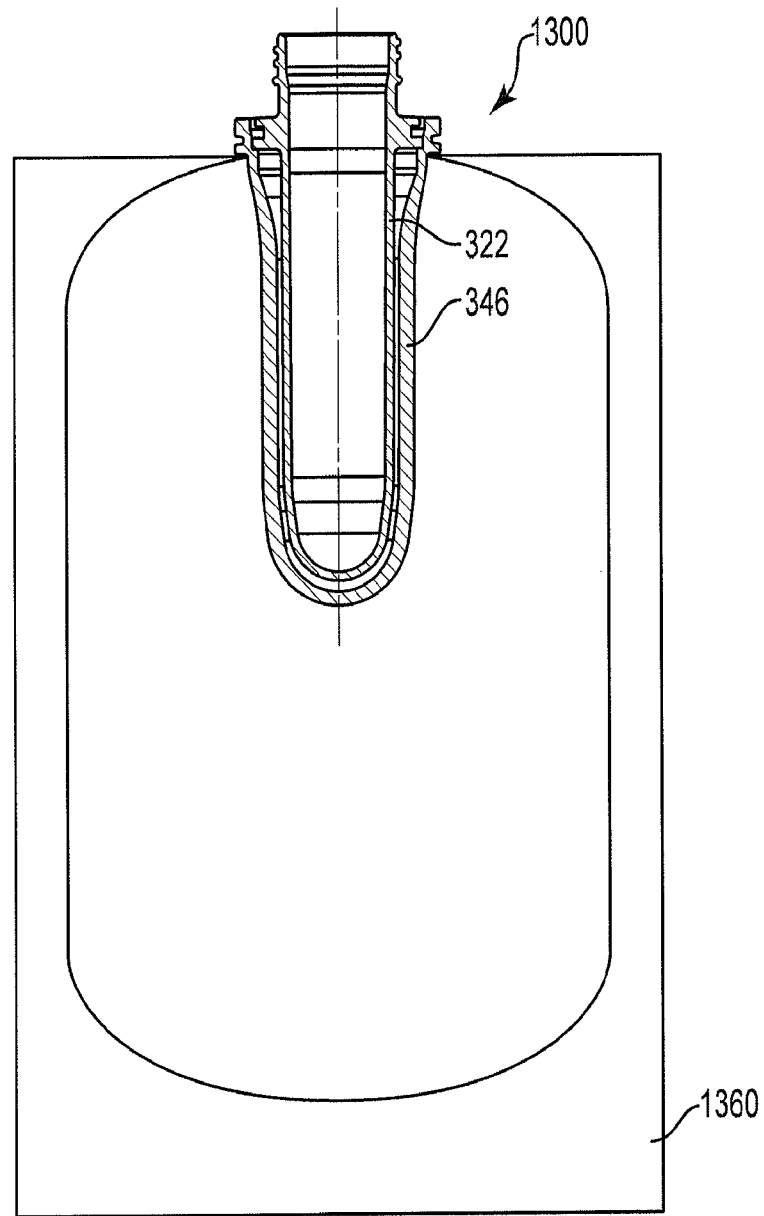
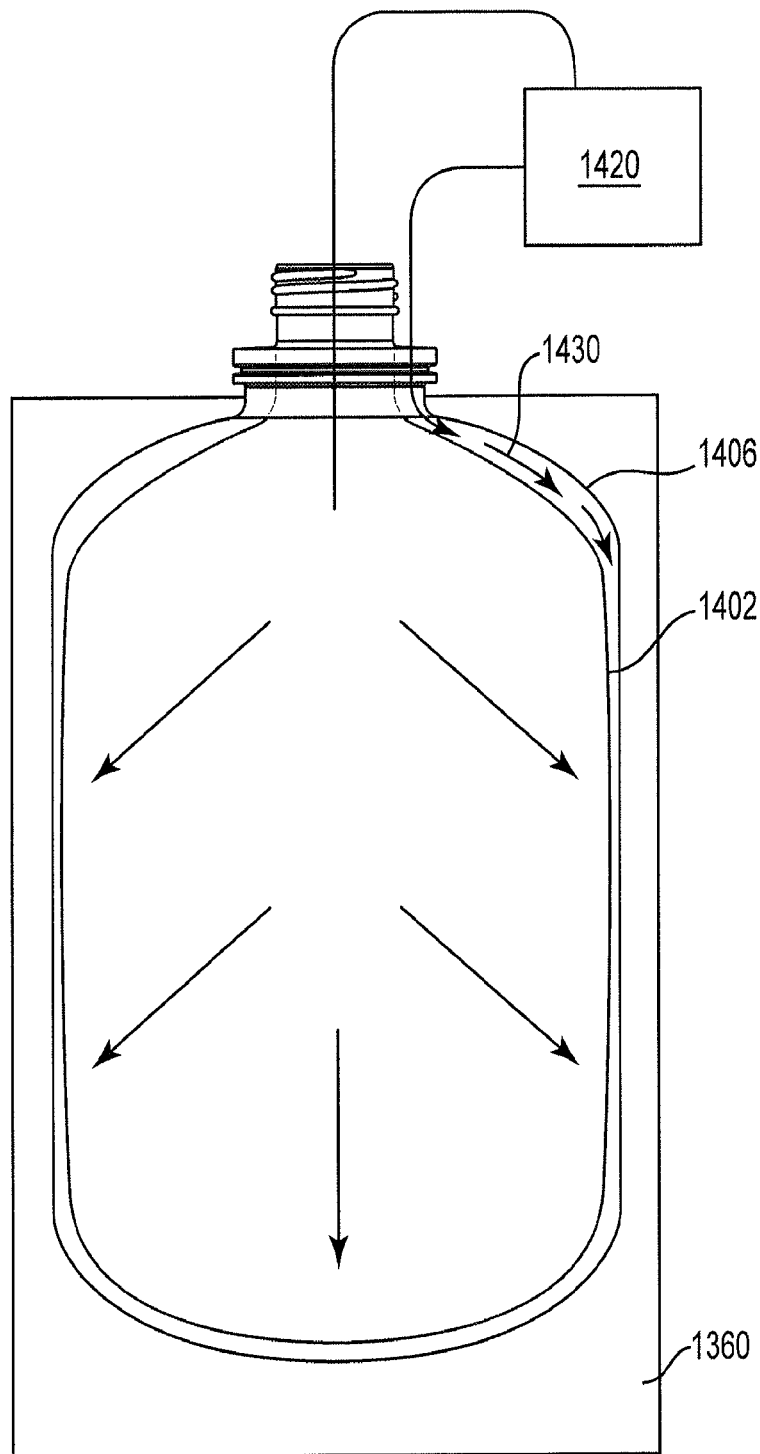
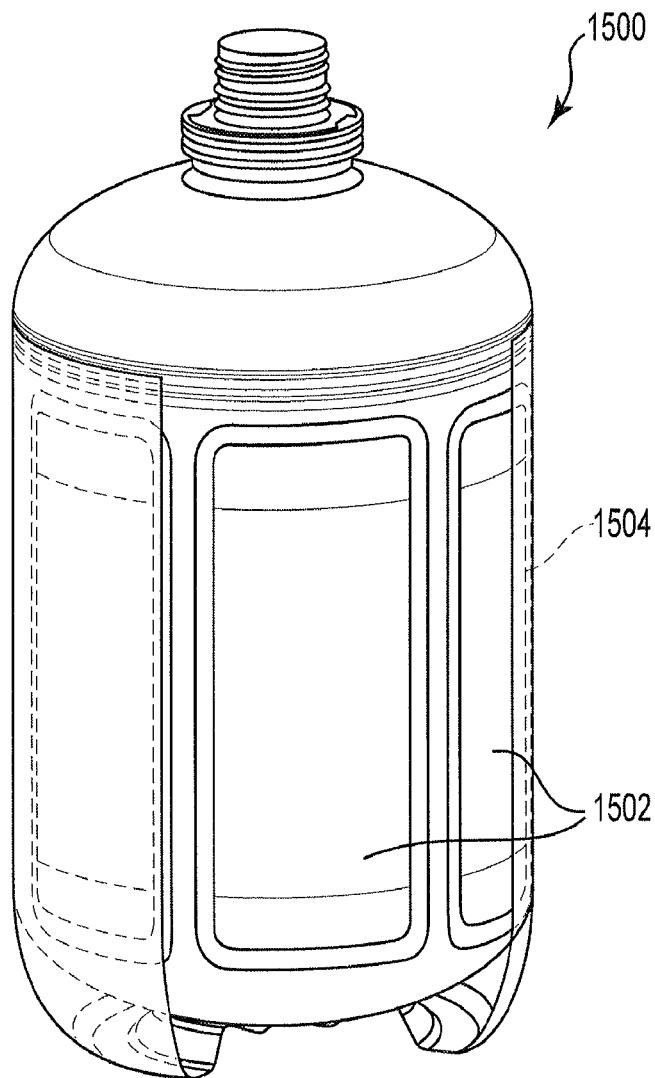
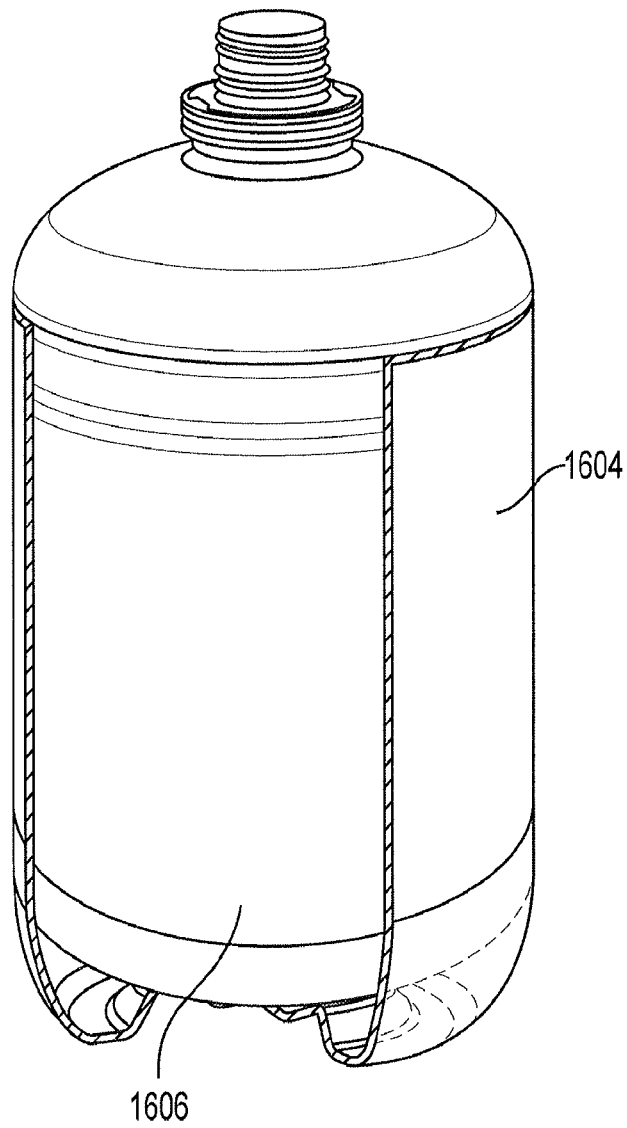


Fig. 13

**Fig. 14**



**Fig. 15**



**Fig. 16**

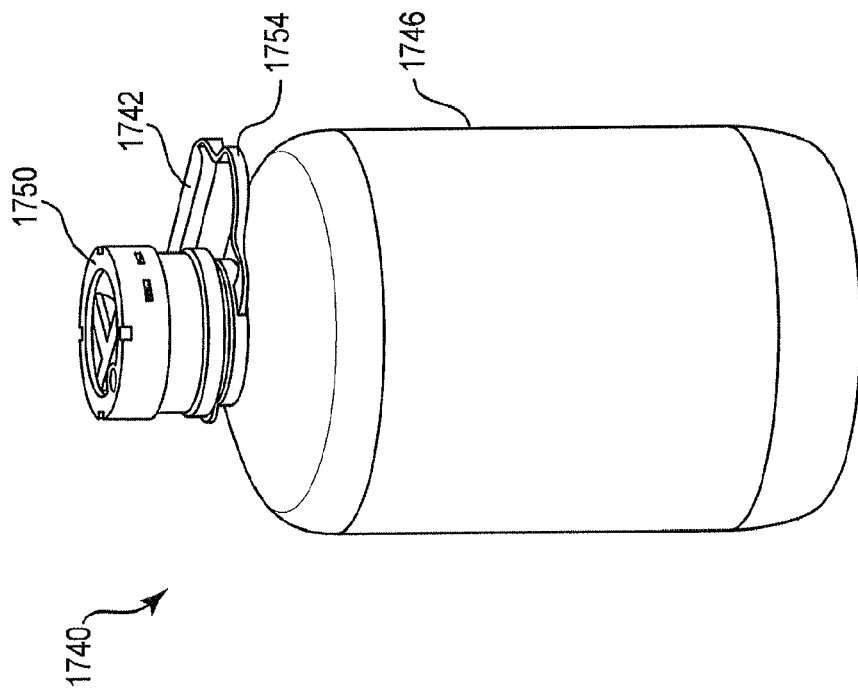


Fig. 17A

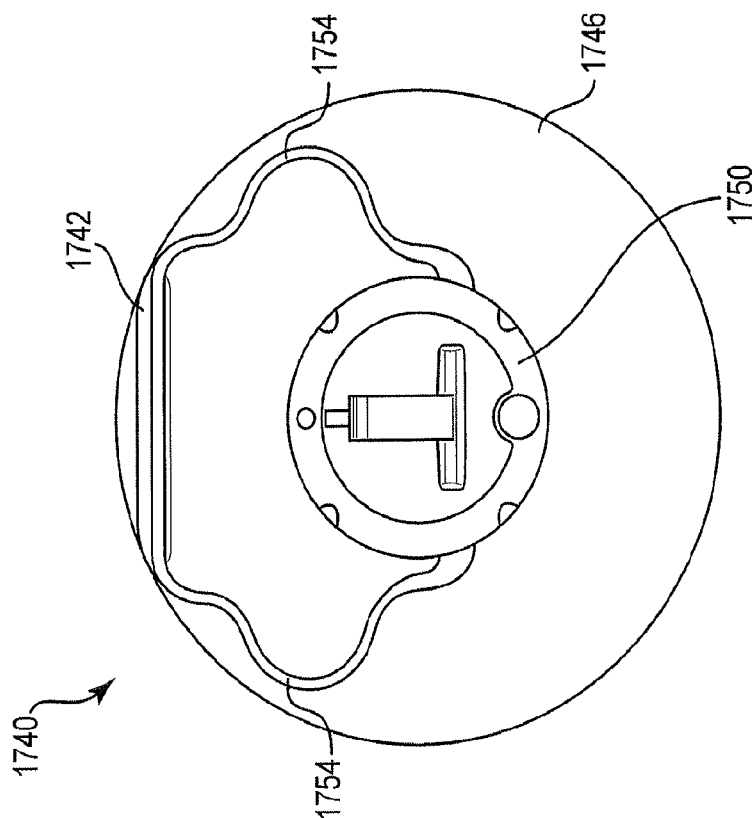


Fig. 17B

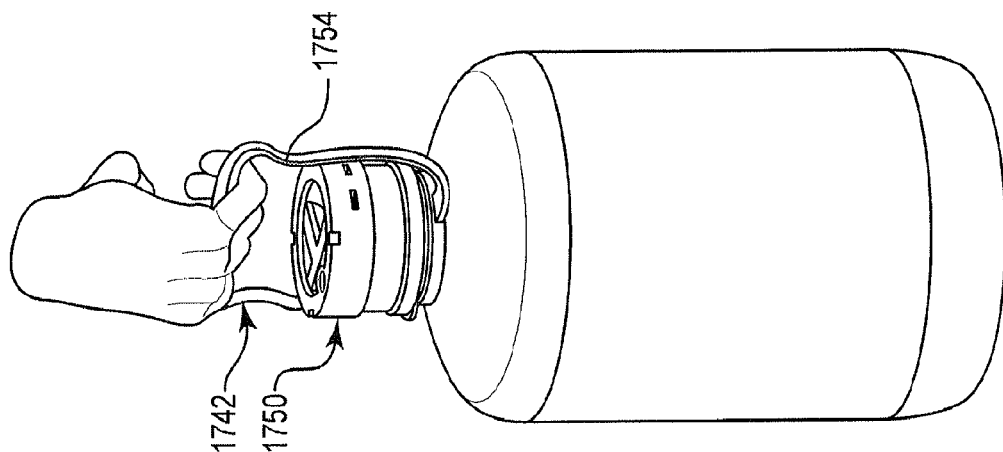


Fig. 17D

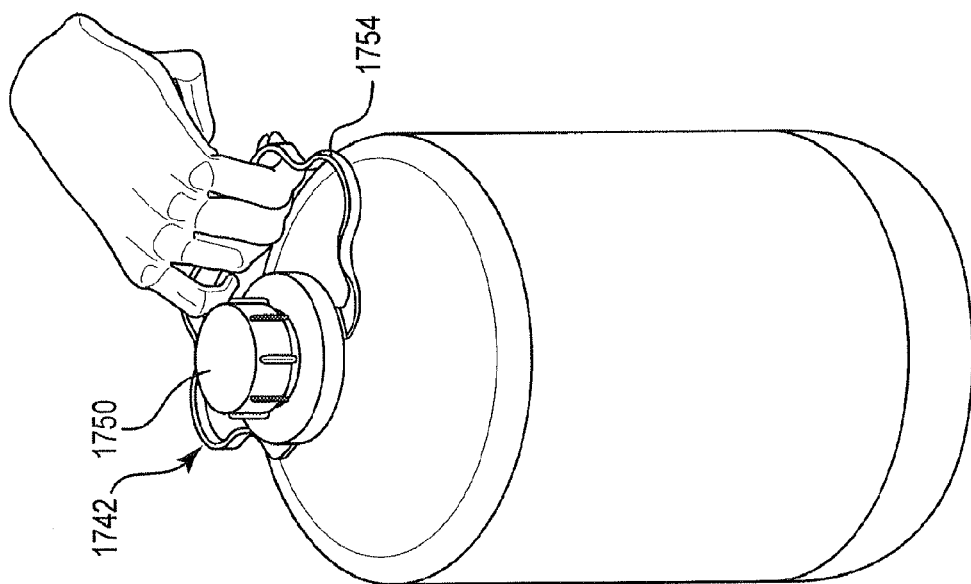


Fig. 17C

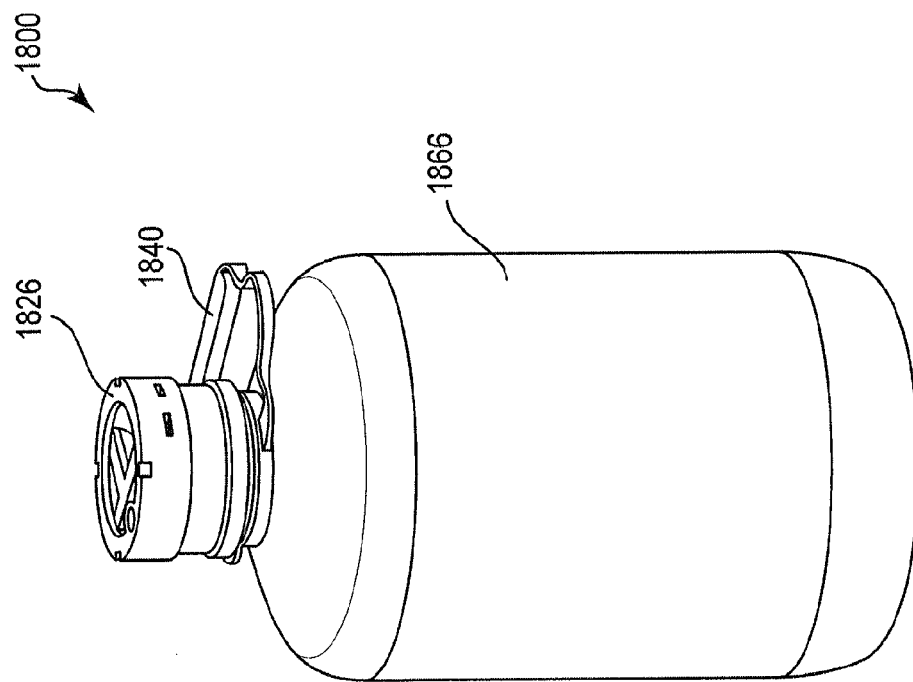


Fig. 18B

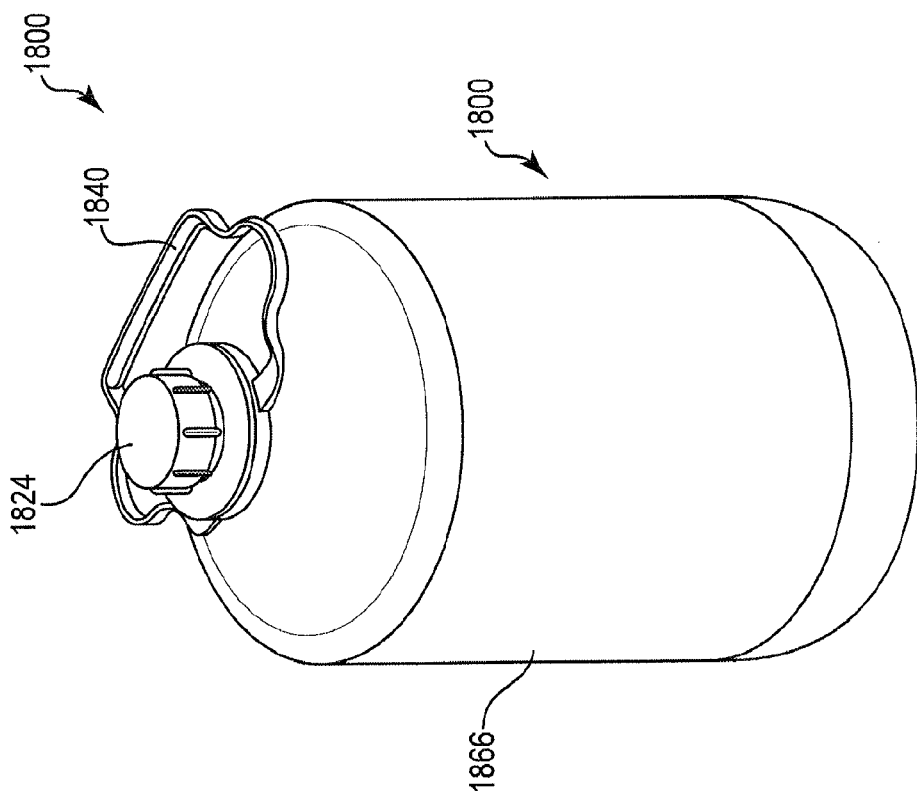


Fig. 18A



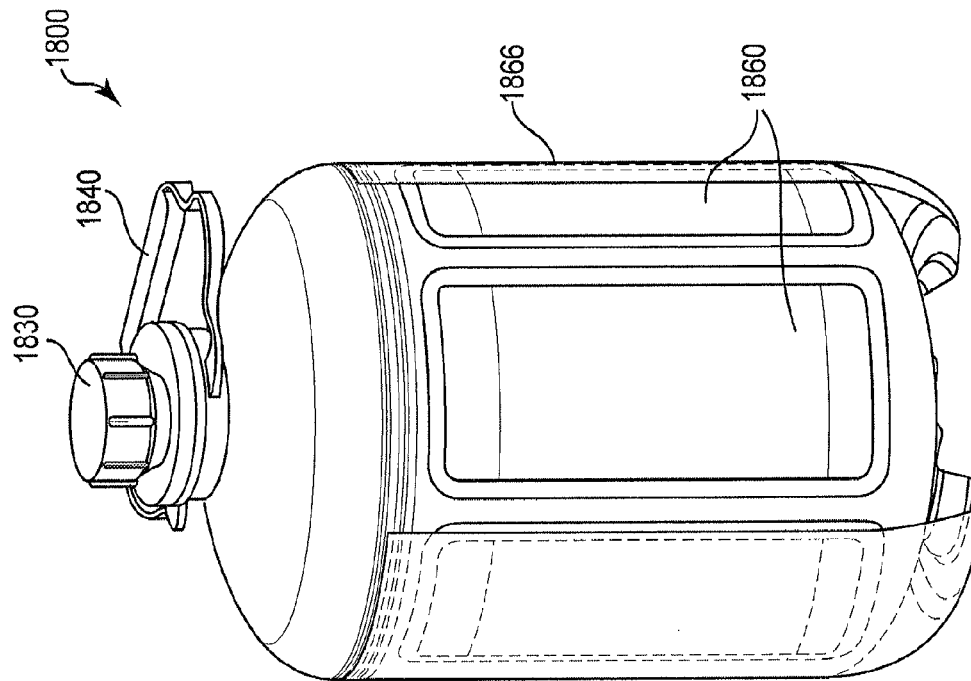


Fig. 18D

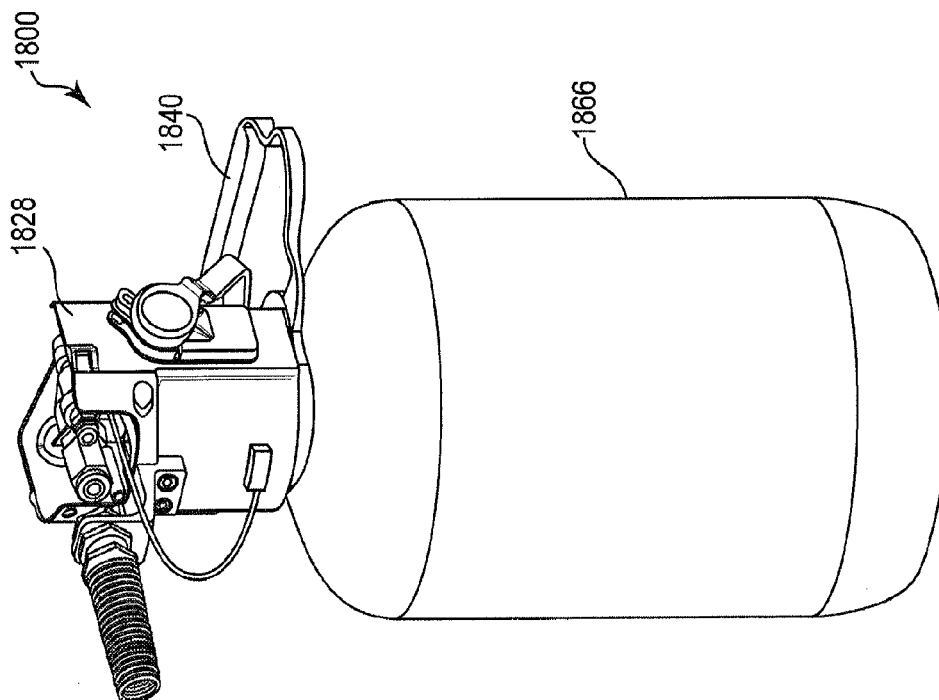


Fig. 18C

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# **NESTED BLOW MOLDED LINER AND OVERPACK AND METHODS OF MAKING SAME**

## **FIELD OF THE INVENTION**

The present disclosure relates to liner-based storage and dispensing systems. More particularly, the present disclosure relates to liner-based systems that are created by a nested blow-molding process.

## **BACKGROUND OF THE INVENTION**

Numerous manufacturing processes require the use of ultrapure liquids, such as acids, solvents, bases, photoresists, slurries, cleaning formulations, dopants, inorganic, organic, metalorganic and biological solutions, pharmaceuticals, and radioactive chemicals. Such applications require that the number and size of particles in the ultrapure liquids be minimized. In particular, because ultrapure liquids are used in many aspects of the microelectronic manufacturing process, semiconductor manufacturers have established strict particle concentration specifications for process chemicals and chemical-handling equipment. Such specifications are needed because, should the liquids used during the manufacturing process contain high levels of particles or bubbles, the particles or bubbles may be deposited on solid surfaces of the silicon. This can, in turn, lead to product failure and reduced quality and reliability.

Examples of the types of containers typically used in the industries include flexible liners, simple rigid-wall containers made of glass or plastic and collapsible liner-based containers. However, current methods of manufacturing liner-based systems may not be as efficient as possible. Thus, there exists a need in the art for better methods of manufacturing liner based systems. In particular, the need exists for more efficient methods of manufacturing liner-based systems where the liner may be comprised of a material that is different from the material comprising the overpack. More particularly, there exists a need for liner-based systems created by a nested blow molding process.

## **BRIEF SUMMARY OF THE INVENTION**

The present disclosure, in one embodiment, relates to a liner-based system comprising a liner disposed within an overpack. The liner and the overpack are made by blow molding the liner and the overpack at the same time using nested preforms.

The present disclosure, in another embodiment, relates to a liner-based system including a liner disposed within an overpack, wherein the liner and overpack are made by blow molding the liner and the overpack at the same time using nested preforms, the liner and the overpack being comprised of different materials having different melting points. The liner may be configured to collapse away from an interior wall of the overpack upon the introduction of a gas or liquid into an annular space between the liner and the overpack, thereby dispensing contents of the liner. The liner and/or overpack may include one or more surface features for controlling the collapse of the liner. The one or more surface features, in some cases, may be a plurality of rectangular-shaped panels spaced around the circumference of the at least one of the liner or overpack. The one or more surface features for controlling the collapse of the liner may be configured to maintain the integrity between the liner and overpack when not in active dispense. In some cases, the system may include a

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chime coupled to the exterior of the overpack. The chime may be coupled to the overpack by snap fit, with the chime substantially entirely covering the one or more surface features. The liner and/or overpack may be configured to control the collapse of the liner such that the liner collapses substantially evenly circumferentially away from the interior wall of the overpack. The liner and/or overpack may each have a barrier coating for protecting contents of the liner. Similarly, the chime may have a barrier coating for protecting the contents of the liner. The liner and/or overpack may, in some cases, include a coating or wrap that at least partially protects contents of the liner from ultra-violet rays. The materials comprising the liner and/or overpack may include additional additives, such as but not limited to an ultra-violet blocking additive, an energy-absorbing additive, an energy releasing additive, or a colorant. The liner and/or overpack preforms can include features to form air channels during the blow mold process that permit gas introduced during pressure dispense or pressure assisted pump dispense to flow more evenly throughout the annular space between the overpack and liner. The liner and/or overpack may have a plurality of wall layers and/or be comprised of a biodegradable material. The liner and overpack walls in an expanded shape may be substantially cylindrical. In some cases, the system may include a handle coupled to at least one of the overpack or liner.

The present disclosure, in yet another embodiment, relates to a method for providing a liner-based system. The method may include providing a liner preform, providing an overpack preform, the material comprising the overpack preform being different than the material comprising the liner preform, heating the liner preform to a first temperature; inserting the heated liner preform into the overpack preform, heating the nested liner and overpack preforms, and blow-molding the heated nested preforms at the same time. The method may also include providing features in at least one of the liner or overpack preforms to form air channels during the blow mold process that permit gas introduced during pressure dispense or pressure assisted pump dispense to flow more evenly throughout the annular space between the overpack and liner. It may also include providing additives in at least one of the materials used to make the liner preform or the overpack preform, the additives comprising at least one of an ultra-violet blocking additive, an energy-absorbing additive, an energy releasing additive, or a colorant.

Embodiments of liners of the present disclosure, in some cases, may be dispensed at pressures less than about 100 psi, or more preferably at pressures less than about 50 psi, and still more preferably at pressures less than about 20 psi, in some cases, the contents of the liners of some embodiments may be dispensed at significantly lower pressures, as described in this disclosure. The present disclosure, in yet another embodiment, relates to an integrated liner-based system having an overpack and a liner provided within the overpack, the liner comprising a mouth and a liner wall forming an interior cavity of the liner and having a thickness such that the liner is substantially self-supporting in an expanded state, but is collapsible at a pressure of less than about 20 psi. The liner and overpack may be made by blow molding the liner and the overpack at the same time using nested preforms.

In another embodiment, the present disclosure relates to a method of delivering a high purity material to a semiconductor process that includes providing a substantially rigid, free-standing container having the high purity material stored in an interior thereof. The container has a container wall comprising polyethylene naphthalate (PEN) and a dip tube in the interior for dispensing the high purity material therefrom.

While multiple embodiments are disclosed, still other embodiments of the present disclosure will become apparent to those skilled in the art from the following detailed description, which shows and describes illustrative embodiments of the invention. As will be realized, the various embodiments of the present disclosure are capable of modifications in various obvious aspects, all without departing from the spirit and scope of the present invention. Accordingly, the drawings and detailed description are to be regarded as illustrative in nature and not restrictive.

### BRIEF DESCRIPTION OF THE DRAWINGS

While the specification concludes with claims particularly pointing out and distinctly claiming the subject matter that is regarded as forming the various embodiments of the present disclosure, it is believed that the invention will be better understood from the following description taken in conjunction with the accompanying Figures, in which:

FIG. 1A is a cross-sectional view of a liner-based system in accordance with an embodiment of the present disclosure.

FIG. 1B is a perspective view of a liner in accordance with an embodiment of the present disclosure.

FIG. 1C is a perspective view of an overpack in accordance with an embodiment of the present disclosure.

FIG. 2A is a side perspective view of a chime in accordance with an embodiment of the present disclosure.

FIG. 2B is a bottom perspective view of a chime in accordance with another embodiment of the present disclosure.

FIG. 2C is a top view of a chime in accordance with yet another embodiment of the present disclosure.

FIG. 2D is a side view of the chime, according to the embodiment shown in FIG. 2C.

FIG. 2E is a bottom view of the chime, according to the embodiment shown in FIG. 2C.

FIG. 2F is a bottom side view of the chime, according to the embodiment shown in FIG. 2C.

FIG. 3A shows a cross-sectional view of nested preforms, according to one embodiment of the present disclosure.

FIG. 3B shows a perspective view of the nested preforms of FIG. 4A.

FIG. 4 is a cross-sectional view of a liner collapsing under pressure dispense in accordance to one embodiment of the present disclosure.

FIGS. 5A-5D show a liner of a liner-based system of the present disclosure being dispensed by pump dispense, in accordance with one embodiment of the present disclosure.

FIGS. 6A-6C show perspective views of the liner-based system of the present disclosure according to some embodiments, wherein the liner-based system had different caps and/or connectors attached.

FIG. 7A shows a view of looking from the bottom inside of an overpack to the top of the overpack, according to one embodiment of the present disclosure.

FIG. 7B is a top view of a liner-based system with air channels according to one embodiment of the present disclosure.

FIG. 7C is a top view of a liner-based system with support rings and air passages according to one embodiment of the present disclosure.

FIG. 7D is view of air channels in an overpack aligning with air passages in a support ring according to one embodiment of the present disclosure.

FIG. 8 is a perspective view of a preform according to one embodiment of the present disclosure.

FIG. 9A is a perspective view of a preform according to another embodiment of the present disclosure.

FIG. 9B is a cross-sectional end view of an embodiment of the preform shown in FIG. 9A, according to one embodiment of the present disclosure.

FIG. 10A is a cross sectional end view of a liner preform and a cross sectional end view of the expanded liner, according to one embodiment of the present disclosure.

FIG. 10B is a perspective view of a preform according to one embodiment of the present disclosure.

FIG. 11A is a perspective view of a liner-based system including surface features according to one embodiment of the present disclosure.

FIG. 11B is a perspective view of a liner-based system including surface features according to another embodiment of the present disclosure.

FIG. 11C is a perspective view of a liner-based system including surface features according to another embodiment of the present disclosure.

FIG. 12A shows the formation of a preform, according to one embodiment of the present disclosure.

FIG. 12B shows removal of a preform from a mold, according to one embodiment of the present disclosure.

FIG. 12C shows a preform being preheated, according to one embodiment of the present disclosure.

FIG. 13 shows a cross-sectional view of nested preforms being inserted into a mold, according to one embodiment of the present disclosure.

FIG. 14 shows co-blow molding of a liner and overpack, according to one embodiment of the present disclosure.

FIG. 15 shows a liner-based system of the present disclosure including surface features according to yet another embodiment of the present disclosure.

FIG. 16 shows a liner-based system of the present disclosure including a chime according to another embodiment of the present disclosure.

FIG. 17A shows a liner-based system of the present disclosure including a handle according to one embodiment of the present disclosure.

FIG. 17B shows another view of the embodiment shown in FIG. 17A.

FIG. 17C shows the embodiment of FIGS. 17A and B, the handle being grasped.

FIG. 17D shows the embodiment of FIGS. 17A-C with the handle being used to pick up the liner-based system

FIG. 18A shows the liner-based system with a dust cap according to one embodiment of the present disclosure.

FIG. 18B shows the embodiment of FIG. 18B with a closure connected to the liner-based system.

FIG. 18C shows the embodiment of FIGS. 18A and B with a dispense connector connected to the liner-based system.

FIG. 18D shows the embodiment of FIGS. 18A-C with another cap connected to the liner-based system and also showing surface features on the liner-based system.

### DETAILED DESCRIPTION

The present disclosure relates to novel and advantageous liner-based storage and dispensing systems and methods of making the same. More particularly, the present disclosure relates to novel and advantageous liner-based storage and dispensing systems and methods for manufacturing such liners using nested co-blow molding. More particularly, in some embodiments, the present disclosure relates to a nested blow-molded, liner-based system whereby the liner and the outer container are comprised of different materials.

Example uses of the liners disclosed herein may include, but are not limited to, transporting and dispensing acids, solvents, bases, photoresists, chemicals and materials for

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OLEDs, such as phosphorescent dopants that emit green light, for example, ink jet inks, slurries, detergents and cleaning formulations, dopants, inorganic, organic, metalorganics, TEOS, and biological solutions, DNA and RNA solvents and reagents, biopharmaceuticals, pharmaceuticals, hazardous waste, radioactive chemicals, and nanomaterials, including for example, fullerenes, inorganic nanoparticles, sol-gels, and other ceramics, and liquid crystals, such as but not limited to 4-methoxybenzylidene-4'-butylaniline (MBBA) or 4-cyano-1,4-bis(4-methoxyphenyl)-1,3,5-triazine (CBOOA). However, such liners may further be used in other industries and for transporting and dispensing other products such as, but not limited to, coatings, paints, polyurethanes, food, soft drinks, cooking oils, agrochemicals, industrial chemicals, cosmetic chemicals (for example, foundations, bases, and creams), petroleum and lubricants, adhesives (for example, but not limited to epoxies, adhesive epoxies, epoxy and polyurethane coloring pigments, polyurethane cast resins, cyanoacrylate and anaerobic adhesives, reactive synthetic adhesives including, but not limited to, resorcinol, polyurethane, epoxy and/or cyanoacrylate), sealants, health and oral hygiene products, and toiletry products, etc. Those skilled in the art will recognize the benefits of such liners and the process of manufacturing the liners, and therefore will recognize the suitability of the liners to various industries and for the transportation and dispense of various products.

As stated above, the present disclosure relates to various embodiments of a nested blow-molded, which may also be referred to herein as co-blow molded, liner-based storage and dispensing system, such as for storage of about 200 L or less of liquid, and more desirably about 20 L or less of liquid, or any other desired volume. Accordingly, the co-blow molded liners may be suitable for storage of high purity liquids, which can be very expensive (e.g., about \$2,500/L or more), that are used in the integrated circuit or flat panel display industries, for example.

As may be seen in FIG. 1A, the liner-based system **100**, manufactured according to some embodiments of the present disclosure, may include a liner **102** that is disposed within an overpack **106**. FIG. 1B shows a liner **102** according to some embodiments of the present disclosure, and FIG. 1C shows an overpack **106** according to some embodiments of the present disclosure. As may be seen, the liner **102** may have substantially the same shape and size as the overpack **106**, except that the liner **102** may be smaller, and in some cases only slightly smaller than the overpack **106**, such that it fits within, and in some cases closely conforms to the interior of the overpack **106**. In some embodiments, the system **100** may include a base cup, support, or chime **118** that may provide support for the system and in some embodiments permit the liner **102** and overpack **106** to stand upright in instances where the bottom of the liner **102** and overpack **106** may be rounded or otherwise unsuited to standing upright. The contents of a liner-based system of the present disclosure may be dispensed by any suitable means, including, for example direct and indirect pressure dispense, pressure assisted pump dispense, and/or pressure assisted gravity dispense.

The liner **102** of the liner-based system may be comprised of any suitable material or combination of materials. For example, in some embodiments, liner **102** may be manufactured using one or more polymers, including plastics, nylons, EVOH, polyolefins, or other natural or synthetic polymers. In further embodiments, liner **102** may be manufactured using polyethylene terephthalate (PET), polyethylene naphthalate (PEN), poly(butylene 2,6-naphthalate) (PBN), polyethylene (PE), linear low-density polyethylene (LLDPE), low-density polyethylene (LDPE), medium-density polyethylene

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(MDPE), high-density polyethylene (HDPE), and/or polypropylene (PP). In some embodiments, the material or materials selected and the thickness of that material or those materials may determine the rigidity of the liner **102**.

In alternative embodiments, liner **102** may be manufactured using a fluoropolymer, such as but not limited to, polychlorotrifluoroethylene (PCTFE), polytetrafluoroethylene (PTFE), fluorinated ethylene propylene (FEP), and perfluoroalkoxy (PFA). In some embodiments, liner **102** may comprise multiple layers. For example, in certain embodiments, liner **102** may include an internal surface layer, a core layer, and an outer layer, or any other suitable number of layers. The multiple layers may comprise one or more different polymers or other suitable materials. For example, the internal surface layer may be manufactured using a fluoropolymer (e.g., PCTFE, PTFE, FEP, PFA, etc.) and the core layer may be a gas barrier layer manufactured using such materials as nylon, EVOH, polyethylene naphthalate (PEN), PCTFE, etc. The outer layer may also be manufactured using any variety of suitable materials and may depend on the materials selected for the internal surface layer and core layer. It is recognized that the various embodiments of substantially rigid liners described herein may be manufactured from any suitable combination of materials disclosed herein.

Liners **102** of the present disclosure may be made of any suitable material, as explained above, may have any desired or suitable thickness, may have any suitable shape, and may be of any suitable type, for example, flexible, rigid collapsible, or glass bottle replacement. Examples of some types of liners that may be used in embodiments of the present disclosure are described in detail in U.S. Patent Appl. No. 61/538,509, titled, "Substantially Rigid Collapsible Liner, Container and/or Liner for Replacing Glass Bottles, and Flexible Gusseted or Non-Gusseted Liners," filed Sep. 23, 2011, which is hereby incorporated herein by reference in its entirety. Preferably, embodiments of the present disclosure include rigid collapsible liners. Such rigid collapsible liners may be any suitable thickness as described above, and may generally be thick and rigid enough to substantially reduce or eliminate the occurrence of pinholes, in some embodiments. In some embodiments, for example, the liner walls and/or overpack walls and/or the walls of the liner and overpack in combination may be from 0.1 to 3.0 mm thick.

The liner wall may generally be thicker than the liners in conventional collapsible liner-based systems. The increased thickness of liner wall and/or the composition of the film comprising the liner increases the rigidity and strength of liner **102**. Because of the rigidity, in one embodiment, liner **102** may be free-standing and used similar to conventional rigid-wall containers, for example glass bottles. In another embodiment, the liner **102** may be free-standing during filling, transportation, and storage. That is, an outer container is not necessary for support of the liner as with liners in conventional collapsible liner-based systems. In one embodiment, a pressure vessel may be used when pressure dispensing liquid from liner **100** during chemical delivery. In a further embodiment, liner **102** may be a free-standing container system. Such embodiments can reduce the overall cost of the container system by substantially eliminating the cost associated with the outer containers. Additionally, in conventional collapsible liner-based systems, the liner and outer container are both typically non-reusable and need to be disposed. In various embodiments of the present disclosure, since an outer container is not necessary, waste can be substantially reduced or minimized because only the liner would be disposed. In one embodiment, the liner wall may be from about 0.05 mm to about 3 mm thick, desirably from about 0.2

mm to about 1 mm thick. However, the thickness may vary depending on the volume of the liner. Generally, liner **102** can be thick and rigid enough to substantially reduce or eliminate the occurrence of pinholes.

As mentioned above, both the composition of the film comprising the liner as well as the thickness of the liner wall can provide rigidity to liner **102**. The thickness is selected so that, when a specified amount of pressure or vacuum is applied to liner **102**, the liner wall is collapsible to dispense liquid from within the interior cavity of the liner **102**. In one embodiment, the dispensability of liner **102** may be controlled based on the thickness selected for liner wall **102**. That is, the thicker liner wall **102** is, the more pressure that will need to be applied to fully dispense the liquid from within the interior cavity. In further embodiments, the liner **102** may be initially shipped in a collapsed or folded state to save shipping space, and allow more liners **102** to be shipped to a recipient, for example a chemical supplier, in one shipment. The liner **102** could subsequently be filled with any of various liquids or products.

As used herein, the terms “rigid” or “substantially rigid,” in addition to any standard dictionary definitions, are meant to also include the characteristic of an object or material to substantially hold its shape and/or volume when in an environment of a first pressure, but wherein the shape and/or volume may be altered in an environment of increased or decreased pressure. The amount of increased or decreased pressure needed to alter the shape and/or volume of the object or material may depend on the application desired for the material or object and may vary from application to application.

Liners of the present disclosure may take a number of advantageous shapes. As can be seen in FIG. 1, in one embodiment, a liner **102** may be configured such that the bottom of the liner is rounded or bowl-shaped **120**. In such embodiments, the degree of rounding may vary. The rounding of the bottom surface may be such that the liner **102** may still be free-standing or self-supporting in some embodiments. Embodiments of liners with rounded bottoms may help improve chemical utilization in, for instance, a pump dispense application as the rounding of the bottom surface may help properly direct a dip tube to the bottom of the liner, for example. Such an embodiment may be particularly useful with liners that are opaque, for instance, which may also help improve chemical utilization and dip tube alignment. A rounded bottom may also be advantageous for embodiments where the contents of the liner are direct pressure dispensed because the rounded bottom may help the liner prevent deformation. A rounded bottom of the overpack may also be advantageous for embodiments where the contents of the liner are indirect pressure dispensed because the rounded bottom may help the overpack prevent deformation when pressurized fluid is added in the annular space between the walls of the overpack and the walls of the liner.

The overpack **106** of the present disclosure, in some embodiments may be comprised of any suitable material such as but not limited to PEN, PET, or PBN, or any suitable mixtures or copolymers thereof, and may exhibit any of the advantageous properties discussed herein. Also, such container may be any suitable thickness as described above, and may generally be thick and rigid enough to substantially reduce or eliminate the occurrence of pinholes, in some embodiments. Examples of some types of overpacks that may be used with embodiments of the present disclosure are described in detail in U.S. Patent Appln. No. 61/538,509, titled, “Substantially Rigid Collapsible Liner, Container and/or Liner for Replacing Glass Bottles, and Flexible Gusseted

or Non-Gusseted Liners,” filed Sep. 23, 2011, which was previously incorporated herein by reference in its entirety.

A support or chime **118**, as shown in FIG. 2A, may also be included in the liner-based system of the present disclosure, in some embodiments. The chime **118** may be made of any suitable material, including, but not limited to any of the materials listed above or any other suitable material or combination of materials. The chime **118** may provide stability for the liner-based system, such that the system may stand upright. The use of a chime **118** may be particularly important and advantageous in use with embodiments of systems that have a rounded bottom. It will be noted, however, that a chime **118** may be used with embodiments of liner/overpack combinations that have a bottom of any shape. The chime **118**, in some embodiments may have feet **220** that may help provide stability to the system. In some embodiments the chime may have any number of feet, including no feet, two feet, four feet, or any other number of feet. The chime **118** may fixedly or detachably secure to the overpack by any suitable means, in some embodiments. For example, the chime **118** may attach by an adhesive, snap-fit, friction fit, welding, or by any other suitable means or combination of means. FIG. 2B shows a chime **218** with multiple feet **220**. FIGS. 2C-2F show different views of a chime **247** according to another embodiment of the present disclosure. In some cases the system **100** of the present disclosure may be made for a single use, whereas in other embodiments, the system **100** of the present disclosure may be reusable. In still other embodiments, some portion of the system **100** (including the system, chime, or both) may be reusable, while other portions may be made for a one-time use. For example, the chime in some embodiments may have connecting features that allow the chime to be removable, such as snap, or twist features, for example, so that the chime may be removed from the overpack and the liner to be reusable, while the liner and overpack may be configured for a one-time use.

Liner-based systems of the present disclosure, in some embodiments, may be blow molded in a nested fashion, also referred to as co-blow molded. Accordingly, the liner and the overpack may be blow-molded at generally the same time, with the liner preform nested within the overpack preform, as will be discussed below.

The liner can be manufactured using any suitable blow molding manufacturing process, such as injection blow molding, injection stretch blow molding, etc. A manufacturing process utilizing blow molding can allow for liners to have more accurate shapes than other manufacturing processes. In some embodiments, the liner and overpack may be co-blow molded using nested blow molding techniques. The co-blow molding process according to some embodiments described herein generally forms an integrated system comprising an overpack and a liner, the overpack and the liner forming an interface where the liner walls join, abut, or otherwise interface or be proximate one another.

FIG. 3A shows a cross-sectional view of a liner preform **322** nested inside of an overpack preform **346**. FIG. 3B shows an outer side view of a liner preform nested inside of an overpack preform.

In one embodiment, the material comprising the liner may be the same as the material comprising the overpack. In another embodiment, however, the material comprising the liner may be different from the material comprising the overpack. For example, in one embodiment, the liner may be comprised of PEN, while the overpack may be comprised of PET or PBN, for example. In other embodiments, the liner and overpack may be comprised of any suitable same or different materials, as described herein.

In some embodiments, one or both of the liner and overpack preform may include various additives to enhance certain properties of the liner and/or overpack. For example, in some embodiments an ultra-violet blocking and/or an energy-absorbing and/or energy releasing additive may be provided to the preform material. Further, in some embodiments the overpack and/or liner may include a color additive, for example, but not limited to a liner and/or overpack that has an amberish hue. It will be recognized, however, that the liner and overpack may be any color or may be clear. In some embodiments, the overpack may have a different color than the liner, while in other embodiments, the overpack and the liner may have the same color.

As stated above, in some embodiments of the present disclosure the materials contained in the liner-based assembly of the present disclosure may be dispensed by any suitable means. FIG. 4 shows a rigid collapsible liner of a liner based system of the present disclosure being collapsed under pressure dispense, according to one embodiment. FIGS. 5A-5D show a liner-based system of the present disclosure in a pump dispense configuration during the process of pump dispense, according to one embodiment. Particularly, FIG. 5A shows a full liner that may be ready to be dispensed by pump dispense. FIG. 5B shows a liner that is half-full due to the contents being dispensed by pump. FIG. 5C shows a liner that is nearly empty and FIG. 5D shows an empty liner dispensed by pump dispense, according to one embodiment of the present disclosure. In FIGS. 4-5D, a section of the overpack has been shown in cut out for purposes of illustration.

In some embodiments, connectors may be used with a rigid collapsible liner to facilitate filling and dispense, as well as to secure the contents of the liner from air and other contaminants during storage. As such, the liner and/or overpack may be adapted to couple with one or more caps and/or connectors and/or connector assemblies. Any suitable connection means is possible, such as for example, threads on a cap and/or connector that are complementary to threads on the fitment of the liner and/or the mouth of the overpack for example, or connecting means may comprise snap fit, friction fit, or any other suitable means. Caps and closures may be used for storage and/or shipping and/or additional protection for keeping contaminants out of the contents of the liner, while connectors may be used with embodiments of the present disclosure for filling the liner and/or dispensing the contents of the liner. Examples of some of the types of caps and/or connectors that may be used with embodiments of the present disclosure are provided in U.S. Patent Application No. 61/538,509, titled, "Substantially Rigid Collapsible Liner, Container and/or Liner for Replacing Glass Bottles, and Flexible Gusseted or Non-Gusseted Liners," filed Sep. 23, 2011; U.S. Provisional Patent Application No. 61/438,338, titled, "Connectors for Liner-Based Dispense Containers," filed Feb. 1, 2011; U.S. Pat. Appl. No. 61/299,427, titled "Closure/Connector for Dispense Containers," which was filed on Jan. 29, 2010, each of which is hereby incorporated herein by reference in its entirety.

FIGS. 6A-C show liner-based systems of the present disclosure according to some embodiments, wherein the liner-based systems have different caps and/or connectors and handles attached thereto.

In some embodiments, features may be incorporated into the system that may help facilitate movement of pressurized air in the annular space and may thereby also decrease the likelihood of pin holes. Pin holing may occur during dispense, such as during pressure dispense or pressure assisted pump dispense. This undesirable outcome may result if the

gas introduced during pressure dispense (indirect or pressure assisted pump dispense) is not able to move freely in the annular space.

FIG. 7A shows a view from inside an overpack looking from the bottom of the overpack up to the top of the overpack. In some embodiments of co-blow molded liner and overpack systems, one or more air channels 702 may be provided between the liner and overpack, for example near the top of the liner and overpack 704, to permit easier and/or more even flow of gas or air into the annular space between the liner and overpack. The air channels may be provided, such as integrally provided, on the liner or the overpack, or both. FIG. 7B shows a top view of an overpack 704 with liner illustrating one embodiment of air channels 702 formed between the liner and overpack. In some embodiments, the air channels 702 may be designed to keep the liner from making complete contact with the overpack at the location of the air channels. The air channels may allow the gas or air that can be introduced during pressure dispense or pressure assisted pump dispense to flow more easily and/or more evenly throughout the annular space between the overpack and liner, thereby eliminating or reducing the occurrence of pin holes. Any number of air channels may be provided, such as but not limited to, from 2-12 air channels; of course, it is recognized that any fewer or greater suitable number of air channels may be provided. Further, the air channels may have any suitable geometry and may be disposed at any suitable place on the overpack. The air channels 702 may be formed from the same material as the overpack in some embodiments, and may protrude from the walls of the overpack, such that the liner may be kept a certain distance from the overpack walls in the area with air channels, thereby allowing gas to flow more freely into the annular space. In some embodiments, the overpack preform may be configured to create the one or more air channels 702. For example, the air channels may be formed by wedge-like protrusions made in the overpack preform. In another embodiment, one or more air channels 702 may be affixed to the overpack after the overpack is formed. In such embodiments, the air channels may be comprised of the same material or any suitable different material than the overpack.

In one embodiment, as shown in FIG. 7C, air passages may also be provided in one or more support rings of the liner or overpack that permit gas or air from an external environment to pass to the air channels, discussed above, and then into the annular space between the overpack and liner. For example, a first support ring 787 may have one or more notches or air passages 782 permitting air flow through the first support ring from an external environment. In one embodiment, the air passages 782 may be circumferentially disposed on the first support ring 787 and may be generally rectangular in shape, as shown, or they may have any other suitable or desirable shape. In some embodiments, the air passages 782 may allow gas or air to flow from the environment of the outer neck area of the overpack 704 into an area between the first support ring 787 and a second support ring 788. The second support ring 788 may comprise one or more additional notches or air passages 786. The air passages 786 may be circumferentially disposed on the second support ring 788 and may be generally pyramidal in shape, as shown, or may have any other suitable or desirable shape. The air passages 786 in the second support ring 788 may allow gas or air to flow from the area between the first support ring 787 and the second support ring 788 into the air channels 702 in the top of the overpack 704 (illustrated in FIG. 74B, and described above). As shown in FIG. 7D, the air channels 702 in the overpack 704 may generally align with the air passages 786 in the second support ring 788, thereby allowing air to pass through the system into the annular space

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between the liner and the overpack. The one or more support rings may be comprised of any suitable material and may be formed in any suitable way, including being integral with the liner or overpack necks in some embodiments, or being affixed, welded, or otherwise coupled to the liner or overpack in other embodiments.

In another embodiment, the ability for gas to flow through the annular space may be increased by including protrusions on the outside wall of a liner preform. As may be seen in FIG. 8, protrusions or recesses **810** may be provided on the liner preform **820**, such that when the liner is formed, the liner has areas that protrude out from the liner wall and/or or dimples that create recesses in the liner wall. The varying protrusions and/or dimples and flush areas **812** may allow the gas to more freely move through the annular space during pressure dispense and/or keep the liner wall from adhering to the interior wall of the overpack. The geometry, pattern, and number of protrusions provided in the liner preform may include any suitable geometry, pattern or number.

In still other embodiments, the ability for gas to flow through the annular space may be increased by further controlling the manner in which the liner collapses during pressure dispense. Controlling the manner of collapse may advantageously keep the dispensing gas moving freely and/or may aid in attaining a high level of dispense. As may be seen in FIG. 9A, in one embodiment, a liner preform **906** may include alternating indentations on the inside **918** of the liner preform and/or on the outside **912** of the liner preform. The indentations **918**, **912** may be vertically disposed along the length of the liner walls, in some embodiments. The indentations **918**, **912** may extend substantially the entire length of the liner or may extend any suitable shorter distance. Any suitable number of indentations **918**, **912** may be provided. In some embodiments, for example, the same number of indentations may be provided on the inside **918** as on the outside **912** of the liner, whereas in other embodiments there may be more or less indentations on the inside **918** of the liner as on the outside **912** of the liner. The indentations may be spaced any suitable distance from one another, and may have any suitable shape. For example, an indentation may vary in thickness or may have a consistent thickness along the entire length of the indentation. The indentations may also curve in some embodiments, while in other embodiments the indentations may be substantially straight. As may be seen in FIG. 9B, a liner preform as shown in FIG. 9A, may generally collapse inward at the points where the outside indentations **912** are located. Generally, the indentations **918**, **912** may act as hinges that control the way the liner collapses.

In another embodiment shown in FIGS. 10A and 10B, panels may be formed in the liner preform in order to create relatively thinner areas that may help control the collapse of the liner. FIG. 10A shows a cross-sectional view of the geometry of the liner preform. As may be seen, a plurality of panels **1001** may be formed in the outside wall of the liner preform **1002**. Any suitable number of panels **1001** may be provided. Further, the panels **1001** may be separated from one another any suitable distance, including varying distances from one another. For example, each panel **1001** may be the same distance away from the panel next to it. In other embodiments, however, the distance between neighboring panels may be different. The panels may have any suitable thickness. In some embodiments, the panels may each have the same thickness, while in other embodiments, some or each of the panels may have a different thickness. The panels **1001** may be areas that are thinner than areas of the preform that do not have panels. When the liner is formed to its expanded state **1012**, the resulting liner wall **1018** may have areas of thick-

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ness that vary, based on which areas included panels and which did not. For example, the liner wall **1018** may be relatively thinner in panel areas than in non-panel areas of the original preform. FIG. 10B shows a perspective view of an embodiment of a preform **1020** with such panels **1022**. During pressure dispense, the thinner areas of the liner may tend to collapse inward first, which may allow for a greater amount of material to be dispensed from the liner and/or may allow the gas to flow more freely through the annular space during dispense.

In some embodiments, the rigid collapsible liner may include other features that may help control when and under what circumstances the liner may collapse. As discussed above, in some embodiments of the present disclosure a liner may be configured to collapse inside of an overpack when a gas or liquid is introduced into the annular space between the liner and the overpack, for example. The collapse of the liner generally forces the contents of the liner out of the liner for dispense. While the liner is intended to collapse during dispense, in some cases the liner may desirably be predisposed against collapsing prior to dispense. For example, when the liner is filled with material and sealed within the overpack at a first temperature and the temperature of the overall system is subsequently lowered, the resulting pressure difference, if significant enough, may cause the liner to undesirably dimple or collapse. For example, if the liner-based system is filled with material at 298° K and the temperature is subsequently lowered to 258° K, there will be a resulting pressure drop inside of the liner-based system. Such a change in pressure may be sufficient to cause the walls to distort or "dimple." Accordingly, in some embodiments the liner may be configured to include features that may make the liner generally resistant to this type of non-dispense related collapse or distortion.

As may be seen in FIG. 11A, in one embodiment, a liner-based system **1102** comprising a liner and an overpack may have a plurality of grooves or other indentation or protrusion pattern **1104**. The grooves **1104** may help maintain the structure of a liner prior to dispense, in the event of a pressure differential caused by, for example but not limited to a change in temperature. As may be seen, in some embodiments, the grooves **1104** may be vertically disposed. The grooves **1104** may extend generally any suitable length along the liner and overpack walls. Further, the grooves **1104** may have any suitable width. In some embodiments, the plurality of grooves **1104** may all have the same height and/or width, while in other embodiments, the grooves may have different heights and/or widths. Any suitable number of grooves **1104** may be disposed on the liner and the overpack walls, spaced any suitable distance apart. The one or more grooves may protrude or indent any suitable amount. For example, in some embodiments the grooves may indent about 1.5 mm. In some embodiments, the grooves may be relatively shallow to minimize loss of internal volume. In another embodiment shown in FIG. 11B, the grooves **1114** may be horizontally disposed. The horizontal grooves **1114** may have any suitable thickness. Further, there may be any suitable number of horizontal grooves **1114** disposed along the walls of the liner and overpack. The horizontal grooves **1114** may extend around the entire circumference of the liner and overpack in some embodiments, while in other embodiments one or more of the grooves **1114** may extend less than the entire circumference of the liner and overpack.

In still other embodiments, other surface features may help reduce or eliminate liner and/or overpack distortion resulting, for example, from a change in temperature. In some embodiments, a liner-based system may include a plurality of geo-

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metric indentations or protrusions. For example, as may be seen in FIG. 11C, a plurality of substantially rectangular indentations 1144 may be provided. While generally rectangular shaped features are shown, it will be understood that the features may have any suitable geometry or combination of geometries. For example, the features may be generally circular, hexagonal, oblong, or any other suitable shape. Similarly, the geometric shape or shapes (in cases where a pattern comprises more than one shape) may be arranged in any suitable pattern, including a substantially random pattern. In some embodiments, the surface features may protrude as opposed to indent. In still other embodiments, some surface features may protrude and other surface features may indent. The plurality of surface features may protrude and/or indent any suitable distance.

In some embodiments, surface features may be similar to those as discussed with respect to FIG. 11C, but may include edges that are generally less defined than those shown therein. For example, the edging that may define a surface feature, such as but not limited to a generally rectangular panel as shown in FIG. 11C, may be substantially more shallow, thereby generally blurring, obscuring, or making more vague the line between the indented (or in other embodiments, protruded) surface feature, and the remainder of the overpack wall. Generally lessening the definiteness of the surface-defining edging may lessen the likelihood that the liner will stick to the overpack during dispense, and/or during any non-dispense contraction caused by temperature change, as discussed above.

As may be seen in FIG. 15, one embodiment of a liner-based system containing surface features may include one or more surface features or panels having a generally rectangular shaped design. Panels may deform reversibly to compensate liner dimpling during temperature change. For example, as may be seen in FIG. 15, six generally rectangular shaped panels 1502 may be vertically disposed along the circumference of the liner and/or overpack walls; however, any other number of panels may be suitably used. As described above, the panels may be symmetrical, each have substantially the same size and shape as the other panels, or in other embodiments, one or more panels may be differently sized and shaped than one or more other panels. For example, one panel may be rigid to provide a space for affixing a label. Also as provided above, the boundary edge that defines a panel 1502 may have any suitable thickness and/or definition, including a shallow depth or a more defined and/or greater depth. In some embodiments, the edging depth may be generally the same for each panel and/or for the entire perimeter of a single panel, while in other embodiments the depth may vary from panel to panel or from one position along the perimeter to another position along the perimeter of the same panel. While the six-panel design is described and shown as a generally rectangularly shaped panels 1502, it will be understood that any suitable or desirable geometry is contemplated and within the spirit and scope of the present disclosure. Further, it will be understood that any suitable number of panels, spaced any suitable distance from one another is contemplated and within the spirit and scope of the present disclosure. Generally, surface features such as one or more panels may add strength and/or rigidity to the liner and/or overpack. However, in some embodiments, as previously described, a more shallow edging may also keep the liner from sticking to the overpack.

In some embodiments, the thickness of the walls of the overpack and/or liner may help or may also help prevent undesirable dimpling. For example, in some embodiments

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the wall thickness of the overpack may be from about 1 to about 3 mm to help prevent temperature related wall distortion.

The surface features shown in FIGS. 11A, B, and C, and FIG. 15 may be formed as described generally above by nested co-blow molding. For example, in some embodiments, the liner and the overpack, once co-blow molded, will have substantially the same form, including substantially the same number and placement of grooves, in accord with the co-blow molding process described above. In still other embodiments, the surface features may only be provided on the liner and not on the overpack, while in still other embodiments, the surface features may only be provided on the overpack and not the liner.

In some cases, a label may desirably be affixed to the outside of a liner-based system. In liner-based systems that include external surface features as have been described herein, a sleeve may be provided over the overpack so as to provide a smooth surface to which the label may adhere. The sleeve may be made of any suitable material, such as plastic, paper, or any other material or combination of materials. The sleeve may completely surround the overpack in some embodiments, while in other embodiments the sleeve may only partially surround the overpack. In some embodiments, including additional or alternative embodiments, shrink wrap may be used on or around the liner-based system for labeling.

In some cases, a label may desirably be affixed to the outside of a liner-based system. In liner-based systems that include external surface features as have been described herein, a sleeve may be provided over the overpack so as to provide a smooth surface to which the label may adhere. The sleeve may completely surround the overpack in some embodiments, while in other embodiments the sleeve may only partially surround the overpack. In other embodiments, a sleeve may additionally or alternatively provide additional support for the overpack. The sleeve for the overpack may extend any suitable height, including substantially the entire height, or any suitable lesser height of the overpack. The additional support provided by the sleeve, may help the overpack resist deformation, particularly prior to pressurized dispense, for example. The sleeve may be substantially completely adhered to the overpack in some embodiments, while in other embodiments, the sleeve may only be secured to the overpack at one or more particular locations. The sleeve may be affixed to the liner or overpack by any suitable means, such as but not limited to adhesive or any other suitable means, or combination of means. The sleeve may be comprised of any suitable material or combination of materials, including, but not limited to, plastic, sturdy paper board, rubber, metal, glass, wood and/or any other suitable material. The sleeve may comprise one or more layers and may include one or more coatings.

In other embodiments, a chime, similar to those shown in FIGS. 2A-F, may be used to provide a smooth generally rigid exterior surface for the liner-based system, which may hide any dimpling effects created by temperature changes, as discussed above, and/or may create a surface for labels and the like. However, in contrast to the chime shown in FIGS. 2A-F, which only covers a generally bottom portion of the liner-based system, a modified chime may cover a greater amount of the liner-based system. In some embodiments, the modified chime may extend generally the entire height of the liner-based system, while in other embodiments, the modified chime may extend any suitable lesser height. As may be seen in FIGS. 15 and 16 for example, a chime 1504, 1604 may extend toward a top portion of the liner or overpack 1606, and in some embodiments may couple to or connect to an upper



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portion of the liner/overpack **1606** by any suitable means, including, but not limited to, snap-fit, friction fit, complementary threading, adhesive, adhesive tape, or any other suitable means. Accordingly, in some embodiments, an upper peripheral edge of the chime **1604** may be glued to the overpack, while in other embodiments the chime **1504**, **1604** may be snapped onto the overpack **1606** by means of snap-fit or friction fit for example at any suitable or desirable location or height on the overpack **1606**. As noted above, because the chime may be comprised of a relatively rigid material in some embodiments, and because the chime may generally fit over a substantial portion of the liner/overpack, if the liner/overpack collapses, dimples, or otherwise distorts, the chime may generally maintain a smooth and rigid shape. As such, any distortion of the liner/overpack may be generally unobservable from the exterior of the liner-based system. Further, the smooth exterior surface of the chime may provide a generally undistorted surface for adhering a label. The chime **1504**, **1604** may be comprised of any suitable material, including plastic, for example high density polyethylene (HDPE), PET or any other suitable polyester, or any other suitable material or plastic, or combination thereof. In FIGS. **15** and **16**, the chime has been shown with a cut out portion for illustration purposes.

In one embodiment, non-dispense related distortion may be minimized or substantially eliminated by configuring a closure or cap to respond to changes in pressure within the liner-based system, generally like a bellows. For example, a cap that may be secured to the liner and/or the overpack during shipping and/or storage may be configured similar to a vertically disposed accordion. The accordion section of the closure may generally be flexible enough to move vertically up and/or down in response to a change in pressure. For example, if the contents of the container are filled at room temperature, the closure is secured, and the temperature subsequently drops, the resulting change in pressure will tend to make the liner-based system collapse inward. Instead of the liner and/or overpack walls collapsing inward, however, the flexible bellows-like closure may be pulled downward into the liner to take up more space in the liner and thereby help equalize the pressure without the liner and/or overpack walls distorting inward, in some embodiments. The bellows-like closure may be comprised of any suitable material or combination of materials, for example, but not limited to plastic, rubber, or any other material, or combination of materials. Further, the bellows-like closure may have any suitable length and/or thickness. In other similar embodiments, a cap may instead generally be a pressurized ballast cap.

Similarly, in some embodiments, the bottom of the overpack and/or liner may be configured with a folding pattern or predetermined fold lines that allow for flexible reaction to pressure changes within the liner-based system, so as to reduce or eliminate non-dispense related distortion. Fold lines at or near the bottom of the overpack and/or liner may take any general shape that may allow the liner-based system to react to non-dispense related changes in pressure. For example, one or more fold lines may be generally configured as a bellows-like closure described above, thereby allowing the bottom of the liner-based system to extend or compress at the flexible fold lines in response to a change in pressure within the liner-based system, resulting from a change in temperature, for example. In other embodiments, the fold lines may create a generally gusseted bottom portion that may allow the sides of the bottom portion of the liner and/or overpack to bend inward or expand outward at the fold lines in response to a change in pressure in the liner-based system. The number and/or placement of the fold lines is not limited

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and may generally include any number of fold lines or configuration of fold lines that may allow for the generally flexible and controlled movement of the liner and/or overpack in response to a change in pressure.

In some embodiments one or more valves, for example one-way valves or check valves, may be incorporated into the liner-based system to substantially equalize any change in pressure that may occur during storage and/or shipping, for example. In such embodiments, a valve may be configured as part of a closure that may allow air to either enter or exit (depending on the configuration of the one-way valve) the annular space between the exterior walls of the liner and the interior walls of the overpack. Allowing air to enter or exist the annular space in response to a change in pressure in the liner-based system may substantially reduce or eliminate non-dispense related distortion. In some embodiments a vent may additionally or alternatively serve a similar purpose. The vent, like a valve, may allow air to enter and/or exit the annular space, in some embodiments, so as to equalize a change in pressure that may occur in the liner-based system. In embodiments that include a valve and/or vent, a desiccant may also be included in the liner-based system. The one or more desiccants may be disposed in the annular space and may generally attract and hold any moisture that may be introduced therein via the vent and/or valve, thereby reducing or preventing the risk of contamination of the contents of the liner.

In another embodiment, the overpack may, or may also be, comprised of carbon fiber for example. Carbon fiber may provide advantages for the overall system and its users at least because it may be generally relatively light weight and strong. The carbon fiber overpack may be any suitable thickness.

In other embodiments, one or more coatings may be applied to the exterior of the liner/overpack to provide additional strength and support for the liner/overpack, such that the liner/overpack may generally resist non-dispense related distortion. Such strengthening coatings may be applied in any suitable thickness, or in any suitable number of layers. Further, one or more different coatings may be applied to the overpack in order to provide suitable strength. The coating(s) may be applied by any suitable method or combination of methods, including by dip coating, spraying, or any other suitable method. In other embodiments, a coating may, or may also be applied to the interior of the overpack. In still other embodiments, a coating may, or may also be applied to the interior of the liner after the liner has been expanded for example.

As explained above, the liner can be manufactured using any suitable blow molding manufacturing process, such as injection blow molding, injection stretch blow molding, etc. A manufacturing process utilizing blow molding can allow for liners to have more accurate shapes than other manufacturing processes. In some embodiments, the liner and overpack may be co-blow molded using blow molding techniques. Co-blow molding a liner and overpack system may advantageously reduce the cost of manufacturing a liner and overpack, as the amount of time and labor involved in the process may be decreased. Additionally, co-blow molding may stress the liner and/or overpack less than traditional manufacturing processes that require the liner to be collapsed and inserted into the overpack. Similarly, particle shedding may be reduced with co-blow molding because the liner does not need to be collapsed to be inserted in the overpack, which may generally cause more particles to shed. Additionally, shipping and transportation may be more efficient and/or cost effective because the liner is already disposed inside, interfaced with, or coupled to the overpack.

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The method may include forming a liner preform by injecting a molten form **1250** of a polymer, for example, into an injection cavity **1252** of a preform mold die **1254**, as illustrated in FIG. **12A**. The mold temperature and the length of time in the mold may depend on the material or materials selected for manufacturing the liner preform. In some embodiments, multiple injection techniques may be used to form a preform having multiple layers. The injection cavity **1252** may have a shape that corresponds to a liner preform **1256** (FIG. **12B**) with integral fitment port **1258**. The polymer may solidify, and the resultant liner preform **1256** may be removed from the preform mold die **1254**. In alternative embodiments, a pre-manufactured preform, including a multilayer preform, can be used for the preform **1256** of the present disclosure.

The same process as described above and shown in FIGS. **12A** and **12B** may be substantially followed in order to create a preform for the overpack. The preform for the overpack may generally be larger than the liner preform so that the liner preform may fit inside of the overpack preform.

Once the liner preform and the overpack preform have been created, the liner preform may be inserted inside of the overpack preform. In some embodiments, prior to inserting the liner preform into the overpack preform, the liner preform **1256** may be heated, as shown in FIG. **12C**. FIG. **3A** shows a cross-sectional view of a liner preform **322** nested inside of an overpack preform **346**. In some embodiments, the liner preform **322** may be manually placed inside of the overpack preform **346**, while in other embodiments, the liner preform **322** may be placed inside of the overpack preform **346** by an automated or generally automated process. In some embodiments, the liner preform **322** may be kept from contacting the overpack preform **346** when the liner preform **322** is placed in the overpack preform **346**. Keeping the preforms from contacting one another may advantageously prevent or reduce the restriction or of one or both preforms getting cold spots or areas of the preform(s) that may be weakened or otherwise adversely affected. As indicated above, FIG. **3B** shows an outer side view of a liner preform **322** nested inside of an overpack preform **346**.

The nested preforms **1300** comprising the liner preform **322** inside of the overpack preform **346**, as illustrated in FIG. **13**, may then be inserted into a liner mold **1360** having substantially a negative image of the desired completed overpack and liner. The nested preforms **1300** may then be blown, or stretched and blown in other embodiments, to substantially the image of the mold **1360**, as illustrated in FIG. **14**, to form the overpack **1406** and liner **1402**. As may be seen in FIG. **14**, an air source **1420** may blow air into the inside of the liner preform such that the liner preform expands and thins to form the liner **1402**. Additionally, in some embodiments, an air source (which may be the same or different from the air source just described) may blow air into the space **1430** between what becomes the overpack **1406** and the liner **1402**. The blow molding air speed, as well as the blow molding temperature and pressure, may depend on the material selected for manufacturing the liner preform and the overpack preform.

Once blown to the image of the mold **1360**, the overpack **1406** and liner **1402** may solidify and be removed from the mold **1360**. The overpack **1406** with the liner **1402** nested inside may be removed from the mold **1360** by any suitable method.

In one embodiment, the material comprising the liner may be the same as the material comprising the overpack. In another embodiment, however, the material comprising the liner may be different from the material comprising the over-

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pack. In embodiments where the materials are different, the melting points of the materials may differ. Therefore, the temperature at which each of the materials may be suitably blow molded may differ. Accordingly, one of the preforms may be preheated (as discussed above with regard to the liner preform) prior to nesting the preforms and co-blow molding them. As discussed above, in some embodiments, the liner preform may be kept from contacting the overpack preform when the liner preform is placed in the overpack preform. Keeping the preforms from contacting one another may advantageously prevent or reduce the risk of one or both preforms getting cold spots or areas of the preform(s) that may be weakened or otherwise adversely affected. In one embodiment, the liner may be comprised of PEN, while the overpack may be comprised of PET or PBN, for example. PEN may need to be blow molded at a higher temperature than PET or PBN because PEN has a higher melting point. Thus, the liner preform comprising PEN may be suitably preheated prior to insertion in the overpack preform and co-blow molding. In other embodiments, the liner and overpack may be comprised of any suitable material as described herein.

Further enhancements may include one or more enhancements provided below and may also include one or more enhancements or other features provided elsewhere in this disclosure. For example, in some embodiments, the exterior and/or interior walls of the liner and/or overpack may have any suitable coating provided thereon. The coating may increase material compatibility, decrease permeability, increase strength, increase pinhole resistance, increase stability, provide anti-static capabilities or otherwise reduce static, etc. Such coatings can include coatings of polymers or plastic, metal, glass, adhesives, etc. and may be applied during the manufacturing process by, for example coating a preform used in blow-molding, or may be applied post manufacturing, such as by spraying, dipping, filling, etc.

In still further embodiments, the liner and/or overpack may be provided with a metal layer or metal coating, for example, but not limited to AL (aluminum), steel, coated steels, stainless steels, Ni (nickel), Cu (copper), Mo (molybdenum), W (tungsten), chromium-copper bi-layer, titanium-copper bi-layer, or any other suitable metal material or combination of materials. In some embodiments, metal coated components may be overcoated with a protective dielectric, for example, SiO<sub>2</sub> from TEOS (tetraethylorthosilicate), or SiCl<sub>4</sub> (silicon tetrachloride), MO (metal organics), TiO<sub>2</sub> from TiCl<sub>4</sub> (titanium tetrachloride), or other suitable metal oxide material, or any other suitable metal, or some combination thereof. Metal coated liners and/or overpacks may be advantageous for storing and shipping substances, including ultra-pure substances, because a metal coating may be substantially impermeable to gases, thus reducing oxidation and/or hydrolysis of the contents and maintaining the purity of the substance contained in the liner and/or overpack. Because of the impermeability of the metal coating, a packaging of this embodiment may be substantially free of pinholes or weld tears and may be very robust and have a consistent fill volume.

In still another embodiment, the overpack may be metal, for example, but not limited to aluminum, nickel, stainless steel, thin-walled steel, or any other suitable metal material or combination of materials. In some embodiments, these metal overpacks may be coated on the internal surface with inert films to reduce interaction of the contents with the metal walls. The films may be inert metals, metal oxides, metal nitrides or metal carbides chosen specifically to reduce the chemical interactions and degradation of the contents inside the metal overpack. In another embodiment, a metal overpack

may have an internal surface coated with glass, plastic, SiO<sub>2</sub>, or any other suitable material or combination of materials. Because of the rigidity of the metal, a storage and/or dispensing system of this embodiment may be substantially free of pinholes or weld tears and may be very robust and have a consistent fill volume.

In one specific embodiment, a storage and dispensing system may include a plastic liner provided with a coating of metal. For example, a liner may be formed of a polymer such as PP, PE, PET, PEN, HDPE or any other suitable polymer, or combination of polymers as described above. The outside of the liner may be metalized with, such as but not limited to aluminum. It will be recognized that any suitable metal may be used to metalize the outside of a polymer liner according to this embodiment. The liner may be metalized by any suitable method, such as, for example, plating, electro-plating, spraying, etc. Metalizing the outside of the liner may substantially decrease or eliminate the effects of gas permeability. Because of the impermeability provided by the metal coating, a liner of this embodiment may be substantially free of pinholes or weld tears and may be very robust and have a consistent fill volume.

Accordingly, each of the embodiments of the present disclosure may be adapted for use with any suitable connector or connection mechanism for dispensing. For example, in some embodiments, the storage and dispense assembly of the present disclosure may include, or permit use of a misconnect prevention closure as well as a misconnect prevention connector. The misconnect prevention closure and misconnect prevention connector, in some embodiments, may be configured such that they are compatible with the NOWPak® dispense system, such as that disclosed in U.S. patent application Ser. No. 11/915,996, titled "Fluid Storage and Dispensing Systems and Processes," which was filed Jun. 5, 2006, which was previously incorporated herein. Samples of the misconnect prevention connector **2650** may be that of ATMI of Danbury, Conn., or those disclosed in U.S. Pat. No. 5,875,921, titled "Liquid Chemical Dispensing System with Sensor," issued Mar. 2, 1999; U.S. Pat. No. 6,015,068, titled "Liquid Chemical Dispensing System with a Key Code Ring for Connecting the Proper Chemical to the Proper Attachment," issued Jan. 18, 2000; U.S. Patent Application No. 60/813,083 filed on Jun. 13, 2006; U.S. Patent Application No. 60/829,623 filed on Oct. 16, 2006; and U.S. Patent Application No. 60/887,194 filed on Jan. 30, 2007, each of which is hereby incorporated by reference in its entirety. In other embodiments, the storage and dispense assembly of the present disclosure may include, or permit use of connectors or connection mechanisms traditionally used for glass bottle storage, transportation, and/or dispense systems. In some embodiments, the connectors or connection mechanisms may be made of any suitable material, which in some cases may depend on its use, and the connectors or connection mechanisms may be sterile, aseptic, etc. In still further embodiments, the connectors or connection mechanisms may be configured for applications that involve recirculation of the contents of the liner and/or overpack.

The storage and dispense assembly of the present disclosure may include one or more ports, which may be used for the processes of filling and dispensing, and may include, for example: a liquid/gas inlet port to allow a liquid or gas to enter the packaging system; a vent outlet; a liquid/gas outlet; and/or a dispense port to permit the contents of the liner to be accessed. The ports may be provided at any suitable location. In one embodiment, the ports may be provided generally at or near the top of the liner and/or overpack. In a further embodiment, the storage and dispense assembly may include a sep-

tum which may be positioned in or adjacent a connector (such as those described above) and may seal the assembly thereby securely containing any substance therein. In some embodiments any or all of the ports and/or septum may be sterilized or aseptic.

In some embodiments, headspace may be removed through a headspace gas outlet or removal port, which may include a tube or canal that leads into the liner, in some embodiments. Generally, the expression "headspace," as used herein, may refer to the gas space in the liner that may rise to the top of the liner, above the contents stored in the liner. By removing headspace gas prior to content dispense, gas that is in direct contact with the liquid can be reduced or substantially eliminated, such that the amount of gas dissolved into the liquid during the dispense process is significantly reduced or minimized. Liquid with minimal dissolved gas generally has less tendency to release gas bubbles after experiencing a pressure drop in the dispense train, and thus, substantially reducing or eliminating gas bubble issues in the liquid dispense system. Generally, headspace in the liner may be removed or reduced by first pressurizing an annular space between the liner and the overpack via a pressure port so that the liner begins to collapse, thereby forcing any excess headspace gas out of the liner through a headspace removal port, or other suitable outlet port.

As described in U.S. Patent Application No. 61/538,509, titled, "Substantially Rigid Collapsible Liner, Container and/or Liner for Replacing Glass Bottles, and Flexible Gusseted or Non-Gusseted Liners," filed Sep. 23, 2011, any of the packaging systems of the present disclosure or one or more components thereof may be shaped or otherwise configured, for example but not limited to, with folding patterns that may include one or more "hard folds" and/or one or more "pre-folds" or "secondary folds" in the rigid collapsible liner and overpack, so as to allow them to substantially uniformly collapse in a desirable manner. In other embodiments, the storage and dispense assemblies of the present disclosure or one or more components thereof may include other shaped structures or features, such as honeycomb structures or features in the walls that can be used to control the collapsing pattern of the packaging system or one or more components thereof. In one embodiment, such structures (e.g., folds, honeycombs, etc.) may be used to control collapse of the assembly or one or more components thereof, such that it collapses radially, without substantially collapsing vertically.

In some embodiments, one or more colors and/or absorbent materials may be added to the materials of the packaging system or one or more components thereof, such as a container, bottle, overpack, or liner, during or after the manufacturing process to help protect the contents of the liner and/or overpack from the external environment, to decorate the assembly, or to use as an indicator or identifier of the contents within the assembly or otherwise to differentiate multiple assemblies, etc. Colors may be added using, for example, dyes, pigments, nanoparticles, or any other suitable mechanism. Absorbent materials may include materials that absorb ultraviolet light, infrared light, and/or radio frequency signals, etc.

In some embodiments, a desiccant, or other sorbent, may be provided in the annular space between the liner and the overpack to adsorb and/or absorb water, oxygen, chemicals, and/or other impurities that may permeate through either inner and/or outer lining. The use of a desiccant may minimize contamination of the material that may result from a rupture in the liner and/or overpack walls, for example. Further, a desiccant may help minimize the possibility of the

material stored in the assembly leaking into the environment as a result of a rupture in the liner and/or overpack.

Similarly, a sorbent material, for example, but not limited to a small cylinder, filled with a gas, a mixture of gasses, and/or a gas generator may be placed in the annular space between the liner and overpack. The sorbent material may be used as a source of pressure for pressure dispense without the need for an external pressure source. The sorbent may release gas by heating the sorbent, by providing electrical pulse, fracture, or any other suitable means or combination of means. Alternatively, the sorbent may be placed in the annular space in the form of beads with a sorbent gas stored therein, for example. The sorbent gas, in the presence of energy, e.g. heat, can desorb from the sorbent medium thereby increasing the pressure in the annular space.

The liners and/or overpacks may be configured as any suitable shape, including but not limited to square, rectangular, triangular or pyramidal, cylindrical, or any other suitable polygon or other shape. Differently shaped liners and/or overpacks can improve packing density during storage and/or transportation, and may reduce overall transportation costs. Additionally, differently shaped liners and/or overpacks can be used to differentiate assemblies from one another, such as to provide an indicator of the contents provided within the assembly or to identify for which application or applications the contents are to be used, etc. In still further embodiments, the assemblies described herein may be configured as any suitable shape in order to "retrofit" the assembly with existing dispense systems.

Additionally, some embodiments of the assembly may include a base or chime component or portion. The chime portion may be an integrated or separate portion or component of the assembly, and may be removable or detachable in some embodiments. With regard to chimes that are separate components, the chime may be attached by any suitable means, including snap-fit, bayonet-fit, friction-fit, adhesive, rivets, screws, etc. Some example chime embodiments are described and/or illustrated in U.S. Prov. Appl. No. 61/538,509, titled, "Substantially Rigid Collapsible Liner, Container and/or Liner for Replacing Glass Bottles, and Flexible Gusseted or Non-Gusseted Liners," filed Sep. 23, 2011, which was previously incorporated herein. The chime may be any suitable size and shape, and may be made from any suitable material, such as the materials described herein. In some embodiments, the chime may be configured to enhance or add stability to the liner and/or overpack for stacking, shipping, strength (e.g., structurally), weight, safety, etc. For example, a chime may include one or more interlocking or mating features or structures that is configured to interlock or mate with a complementary feature of an adjacent container, either vertically or horizontally, for example. As described for example in U.S. Prov. Appl. No. 61/538,509, titled, "Substantially Rigid Collapsible Liner, Container and/or Liner for Replacing Glass Bottles, and Flexible Gusseted or Non-Gusseted Liners," filed Sep. 23, 2011, which was previously incorporated herein, a liner and/or overpack may include a generally rounded or substantially rounded bottom. A rounded bottom can help increase dispensability of the contents therein, particularly in pump dispense applications. A chime may be used to provide support for such liners and/or overpacks. Further in some embodiments, a chime may be coupled to a liner without an overpack. Such an embodiment may be dispensed by pump dispense, for example.

In some embodiments, the liners and/or overpacks described herein may include symbols and/or writing that is molded into the liner and/or overpack. Such symbols and/or writing may include, but are not limited to names, logos,

instructions, warnings, etc. Such molding may be done during or after the manufacturing process of the liner and/or overpack. In one embodiment, such molding may be readily accomplished during the fabrication process by, for example, embossing the mold for the liner and/or overpack. The molded symbols and/or writing may be used, for example, to differentiate products.

Similarly, in some embodiments, the liner and/or overpack may be provided with different textures or finishes. As with color and molded symbols and/or writing, the different textures or finishes may be used to differentiate products, to provide an indicator of the contents provided within the liner and/or overpack, or to identify for which application or applications the contents are to be used, etc. In one embodiment, the texture or finish may be designed to be a substantially non-slip texture or finish or the like, and including or adding such a texture or finish to the liner and/or overpack may help improve graspability or handling of the liner and/or overpack, and thereby reduce or minimize the risk of dropping of the liner and/or overpack. The texture or finish may be readily accomplished during the fabrication process by, for example, providing a mold for the liner and/or overpack with the appropriate surface features. In other embodiments, the molded liner and/or overpack may be coated with the texture or finish. In some embodiments, the texture or finish may be provided on substantially the entire liner and/or overpack or substantially the entirety of one or more components thereof. However, in other embodiments, the texture or finish may be provided on only a portion of the liner and/or overpack or a portion of one or more components thereof.

In some embodiments, the interior walls of the liner and/or overpack thereof may be provided with certain surface features, textures, or finishes. In embodiments wherein the assembly comprises an overpack and liner, or multiple liners, etc., the interior surface features, textures, or finishes of the overpack, or one or more of the liners, may reduce adhesion between the overpack and liner, or between two liners. Such interior surface features, textures, or finishes can also lead to enhanced dispensability, minimized adhesion of certain materials to the surface of the overpack or liner(s), etc. by controlling, for example, the surface hydrophobicity or hydrophilicity.

In some embodiments, the liner and/or overpack include one or more handles. The one or more handles can be of any shape or size, and may be located at any suitable position of the liner and/or overpack. Types of handles can include, but are not limited to, handles that are located at the top and/or sides; are ergonomic; are removable or detachable; are molded into the liner and/or overpack or are provided after fabrication of the assembly (such as by, for example, snap fit, adhesive, riveting, screwed on, bayonet-fit, etc.); etc. Different handles and/or handling options can be provided and may depend on, for example but not limited to, the anticipated contents of the liner and/or overpack, the application for the assembly, the size and shape of the assembly, the anticipated dispensing system for the assembly, etc.

In some embodiments, as shown in FIGS. 17A-D, a flexible or elastic handle may be molded to be compact to fit into shipping boxes and equipment. When lifted, the handle may expand to provide clearance for hands or for different size closures. Upon release, the handle may return to its original compact shape and position. In some embodiments, as shown in FIGS. 17A-D, a handle 1742 may be used to lift and or move the liner-based system 1740. The handle 1742 may be any color and may be made from any suitable material or combination of materials, for example, plastic. As may be seen, in some embodiments, the handle 1742 may be config-

ured so as not extend beyond the circumference of the container 1746 when the handle is in a horizontal position. In further embodiments, the handle 1742, when in an unused position, for example, may have one or more bulge areas, or expansion areas, 1754 that may be configured to generally straighten out when the handle 1742 is pulled generally vertically, or otherwise in use by the user. Accordingly, when the handle 1742 is positioned in an in-use or carrying position, as shown for example in FIGS. 17C and D, in some embodiments, the handle 1742 may expand or stretch due to the give in the expansion areas 1754. For example, in some embodiments, the handle may expand by about 1/2 to 1 1/2 inches when lifting the handle 1742. In other embodiments, the handle may be configured to expand more or less as appropriate. The ability of the handle to expand while in the carrying position may advantageously allow the handle to stay within the circumferential dimensions of the container while in a unused position, such that the handle does not get damaged during shipping or storage for example. The expansion of the handle while in the in-use or carrying position can also permit the handle to clear certain caps and/or connectors 1750.

In some embodiments, the storage and dispense assembly may include two or more layers, such as an overpack and a liner, multiple overpacks, or multiple liners. In further embodiments, a packaging system may include at least three layers, which may help ensure enhanced containment of the contents therein, increase structural strength, and/or decrease permeability, etc. Any of the layers may be made from the same or different materials, such as but not limited to, the materials previously discussed herein.

In some embodiments, the assembly may comprise a single wall overpack or liner. In even further embodiments, the single wall may comprise PEN. In another embodiment, the assembly may comprise a liner that is made of a flexible glass type or a flexible glass/plastic hybrid. Such flexible glass liner may reduce or eliminate the permeation of oxygen and water into the contents stored therein. A flexible glass liner may also add the ability of withstanding chemicals or chemistries not compatible with other materials, such as PEN or other plastics.

In order to assist in making the assemblies described herein more sustainable, the assembly or one or more components thereof, including any overpack, liner(s), handles, chimes (support members), connectors, etc., may be manufactured from biodegradable materials or biodegradable polymers, including but not limited to: polyhydroxyalkanoates (PHAs), like poly-3-hydroxybutyrate (PHB), polyhydroxyvalerate (PHV), and polyhydroxyhexanoate (PHH); polylactic acid (PLA); polybutylene succinate (PBS); polycaprolactone (PCL); polyanhydrides; polyvinyl alcohol; starch derivatives; cellulose esters, like cellulose acetate and nitrocellulose and their derivatives (celluloid); etc.

In some embodiments, the assembly or one or more components thereof may be manufactured from materials that can be recycled or recovered, and in some embodiments, used in another process by the same or a different end user, thereby allowing such end user(s) to lessen their impact on the environment or lower their overall emissions. For example, in one embodiment, the assembly or one or more components thereof may be manufactured from materials that may be incinerated, such that the heat generated therefrom may be captured and incorporated or used in another process by the same or different end user. In general the assembly or one or more components thereof may be manufactured from materials that can be recycled, or that may be converted into raw materials that may be used again.

In some embodiments, structural features may be designed into the liner and/or overpack that add strength and integrity to the assembly or one or more components thereof. For example, the base (or chime in some embodiments), top, and sides of the assembly may all be areas that experiences increased shake and external forces during filling, transportation, installation, and use (e.g., dispensing). Accordingly, in one embodiment, added thickness or structural edifices (e.g., bridge tressel design) may be added to support stressed regions of the packaging, which can add strength and integrity to the assembly. Furthermore, any connection region in the assembly may also experience increased stress during use. Accordingly, any of these such regions may include structural features that add strength through, for example, increased thickness and/or specifically tailored designs. In further embodiments, the use of triangular shapes could be used to add increased strength to any of the above described structures; however, other designs or mechanical support features may be used.

In some embodiments, the assembly or one or more components thereof, including any overpack or liner(s), may include reinforcement features, such as but not limited to, a mesh, fiber(s), epoxy, or resin, etc. that may be integrated or added to the assembly or one or more components thereof, or portions thereof, in order to add reinforcement or strength. Such reinforcement may assist in high pressure dispense applications, or in applications for dispensing high viscosity contents or corrosive contents.

In further embodiments, flow metering technology may be either separate or integrated into the dispense connector for a direct measurement of material being delivered from the liner and/or overpack to a down stream process. A direct measurement of the material being delivered could provide the end user with data which may help ensure process repeatability or reproducibility. In one embodiment, the integrated flow meter may provide an analog or digital readout of the material flow. The flow meter, or other component of the system, can take the characteristics of the material (including but not limited to viscosity and concentration) and other flow parameters into consideration to provide an accurate flow measurement. Additionally, or alternatively, the integrated flow meter can be configured to work with, and accurately measure, a specific material stored and dispensed from the liner and/or overpack. In one embodiment, the inlet pressure can be cycled, or adjusted, to maintain a substantially constant outlet pressure or flow rate.

In some embodiments, the assembly may include level sensing features or sensors. Such level sensing features or sensors may use visual, electronic, ultrasonic, or other suitable mechanisms for identifying, indicating, or determining the level of the contents stored in the packaging system. For example, in one embodiment, the storage and dispense assembly or a portion thereof may be made from a substantially translucent or transparent material that may be used to view the level of the contents stored therein.

In still further embodiments, the assembly may be provided with other sensors and/or RFID tags, which may be used to track the assembly, as well as to measure usage, pressure, temperature, excessive shaking, disposition, or any other useful data. The RFID tags may be active and/or passive. For example, strain gauges may be used to monitor pressure changes of the assembly. The strain gauges may be applied or bonded to any suitable component of the assembly. In some embodiments, the strain gauges may be applied to an outer overpack or liner. The strain gauges may be used to determine pressure build-up in an aging product, but may also be useful for a generally simple measurement of the contents

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stored in the assembly. For example, the strain gauge may be used to alert an end user when to change out a liner and/or overpack or may be used as a control mechanism, such as in applications where the assembly is used as a reactor or disposal system. In embodiments where the sensitivity of the strain gauge is high enough, it may be able to provide a control signal for dispense amount and flow rate.

In one particular embodiment, as discussed above, a liner-based system may include a co-blow molded liner and overpack with substantially co-extensive surface features and a base cup or chime, as may be seen in FIGS. 18A-D. The liner-based system 1800 may be configured to couple with a variety of different caps, closures, and/or connectors of the type described herein. FIG. 18A shows the liner-based system coupled with a temporary cap or dust cap 1824 that may be used for storage and/or shipping. FIG. 18B shows the liner-based system 1800 coupled with a closure 1826. The closure 1826 may secure the contents of the liner-based system 1800 during storage and/or shipping, but may also be configured to couple with a connector for dispense. FIG. 18C, for example, shows the liner-based system 1800 coupled with a pressure dispense connector 1828. And, FIG. 18D shows the liner-based system 1800 coupled to yet another cap 1830 that may be used to secure the contents of the liner-based system 1800 during storage and/or shipping. The additional coverage provided by cap 1830, as opposed to cap 1824, for example, may advantageously shield the contents of the liner from light; may prevent or reduce the risk of environmental moisture entering the contents of the liner; and/or may provide secondary containment because the cap 1830 may be secured to and/or cover both the liner fitment and the overpack, in some embodiments. Each of FIGS. 18A-D shows the liner-based system 1800 including a handle 1840 of the type disclosed herein that may be flexible and expand when the handle 1840 is used to pick up and/or move the liner-based system 1800. The liner may be what has been referred to herein as a substantially rigid collapsible liner. The liner and/or overpack may include one or more barriers and/or coatings as described herein. The liner and/or overpack may be substantially smooth surfaced or may include surface features as generally described above, including rectangular shaped panels 1860, such as six panels, around the circumference of the liner and overpack, as shown in FIG. 18D. The panels 1860 may be generally evenly spaced and of substantially the same size and shape. The panels may have a height generally equal to the non-sloping height of the liner and overpack; that is, the panels may not extend to cover the top or bottom portions of the liner and overpack that begin to slope or curve toward the mouth or bottom of the liner and overpack. The embodiment may also include a base cup or chime 1866 that may have a height sufficient to generally cover the rectangular panel surface features 1860. The chime 1866 may provide added strength to the system 1800 and may also provide a smooth surface for attaching labels. The base cup 1866 may include a colorant or other additives to protect the liner and overpack 1800 from, for example, UV or infrared light. The overpack may include connecting features for connecting to the chime, including adhesive or snap-fit features that allow the chime 1866 to be detachably coupled to the overpack. The mouth and/or neck of the liner and/or overpack may be configured to couple with existing glass bottle pump dispense systems, such that the liner and overpack may be used as a replacement for existing glass bottles. In addition, the mouth and/or neck of the liner and/or overpack may be configured to couple with and/or existing pressure dispense connectors. As pressurized gas or liquid is introduced into the annular space between the interior walls of the overpack and the exterior walls of the

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liner during pressure dispense, the liner may be particularly configured to collapse in upon itself and away from the walls of the overpack.

As explained herein, various features of liner-based systems disclosed in embodiments described herein may be used in combination with one or more other features described with regard to other embodiments. That is, liners of the present disclosure may include any one or more of the features described herein, whether or not described as the same or another embodiment. For example only, any embodiment (unless specifically stated otherwise) may be dispensed by direct or indirect pressure dispense, pump dispense, pressure assisted pump dispense, gravity dispense, pressure assisted gravity dispense, or any other method of dispense; may include any number of layers; may have layers made of the same or different materials; may include a liner made of the same or different material as the overpack; may have any number of surface or structural features; may be filled with any suitable material for any suitable use; may be filled by any suitable means, using any suitable cap or connector; may have one or more barrier coatings; may include a sleeve, chime, or base cup; may be configured for use with any one or more caps, closures, connectors, or connector assemblies as described or illustrated herein; the material comprising the liner and/or overpack may include one or more additives; and/or the liners, overpacks, or liner-based systems may have any other combination of features herein described. While some embodiments are particularly described as having one or more features, it will be understood that embodiments that are not described are also contemplated and within the spirit and scope of the present disclosure, wherein those embodiments comprise any one or more of the features, aspects, attributes, properties or configurations or any combination thereof of storage and dispense systems described herein.

Although the present invention has been described with reference to preferred embodiments, persons skilled in the art will recognize that changes may be made in form and detail without departing from the spirit and scope of the invention.

We claim:

1. A liner-based system comprising:

a collapsible liner disposed within an overpack configured to dispense a fluid contained within the collapsible liner by collapsing the collapsible liner, wherein the liner and overpack are made by blow molding the liner and the overpack at the same time using nested preforms, the collapsible liner and the overpack being comprised of different materials having different melting points, wherein the liner has a thickness such that the liner is substantially self-supporting in an expanded state, and wherein the collapsible liner defines surface features configured to be predisposed against collapsing of the collapsible liner when not in active dispense, the surface features of the collapsible liner defining a plurality of vertically disposed grooves and a plurality of horizontally disposed grooves along a circumference of the collapsible liner, wherein the plurality of vertically disposed grooves of the collapsible liner and the plurality of horizontally disposed grooves of the collapsible liner outline a plurality of rectangular-shaped panels spaced around the circumference of the collapsible liner.

2. The liner-based system of claim 1, wherein the collapsible liner is configured to collapse away from an interior wall of the overpack upon the introduction of a gas or liquid into an annular space between the collapsible liner and the overpack, thereby dispensing contents of the collapsible liner.

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3. The liner-based system of claim 2, wherein the plurality of vertically disposed grooves of the collapsible liner and the plurality of horizontally disposed grooves of the collapsible liner are configured to control the collapse of the liner.

4. The liner-based system of claim 1, further comprising a chime coupled to the exterior of the overpack.

5. The liner-based system of claim 4, wherein the chime is coupled to the overpack by snap fit, the chime substantially entirely covering the one or more surface features.

6. The liner-based system of claim 2, wherein at least one of the collapsible liner or overpack are configured to control the collapse of the collapsible liner such that the collapsible liner collapses substantially evenly circumferentially away from the interior wall of the overpack.

7. The liner-based system of claim 2, wherein at least one of the collapsible liner and overpack comprises a barrier coating for protecting contents of the collapsible liner.

8. The liner-based system of claim 2, wherein at least one of the collapsible liner and overpack include a coating or wrap that at least partially protects the contents of the collapsible liner from ultra-violet rays.

9. The liner-based system of claim 2, wherein at least one of the materials comprising the collapsible liner and overpack include additional additives, the additives comprising at least one of an ultra-violet blocking additive, an energy-absorbing additive, an energy releasing additive, or a colorant.

10. The liner-based system of claim 2, wherein at least one of the collapsible liner and overpack preforms include features to form air channels during the blow mold process that permit gas introduced during pressure dispense or pressure assisted pump dispense to flow more evenly throughout the annular space between the overpack and collapsible liner.

11. The liner-based system of claim 2, wherein at least one of the collapsible liner and overpack comprises a plurality of wall layers.

12. The liner-based system of claim 2, wherein at least one of the collapsible liner and overpack are comprised of a biodegradable material.

13. The liner-based system of claim 2, wherein the collapsible liner and overpack walls in an expanded shape are substantially cylindrical.

14. The liner-based system of claim 5, further comprising a handle coupled to at least one of the overpack and the collapsible liner.

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15. An integrated liner-based system comprising:  
an overpack; and

a collapsible liner provided within the overpack, the collapsible liner comprising a mouth and a liner wall forming an interior cavity of the collapsible liner and having a thickness such that the liner is substantially self-supporting in an expanded state, but is collapsible at a pressure of less than about 20 psi;

wherein the liner and overpack are made by blow molding the liner and the overpack at the same time using nested preforms; and

wherein the collapsible liner defines surface features configured to be predisposed against collapsing of the collapsible liner when not in active dispense, the surface features of the collapsible liner defining a plurality of vertically disposed grooves and a plurality of horizontally disposed grooves along a circumference of the collapsible liner,

wherein the plurality of vertically disposed grooves of the collapsible liner and the plurality of horizontally disposed grooves of the collapsible liner outline a plurality of rectangular-shaped panels spaced around the circumference of the collapsible liner.

16. The integrated liner-based system of claim 15, wherein the overpack defines a plurality of vertically disposed grooves and a plurality of horizontally disposed grooves along a circumference of the overpack, the plurality of vertically disposed grooves of the overpack being co-extensive with the plurality of vertically disposed grooves of the collapsible liner, and the plurality of horizontally disposed grooves of the overpack being co-extensive with the plurality of horizontally disposed grooves of the collapsible liner.

17. The liner-based system of claim 1, wherein the overpack defines a plurality of vertically disposed grooves and a plurality of horizontally disposed grooves along a circumference of the overpack, the plurality of vertically disposed grooves of the overpack being co-extensive with the plurality of vertically disposed grooves of the collapsible liner, and the plurality of horizontally disposed grooves of the overpack being co-extensive with the plurality of horizontally disposed grooves of the collapsible liner.

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UNITED STATES PATENT AND TRADEMARK OFFICE  
**CERTIFICATE OF CORRECTION**

PATENT NO. : 9,211,993 B2  
APPLICATION NO. : 14/001713  
DATED : December 15, 2015  
INVENTOR(S) : Tom et al.

Page 1 of 1

It is certified that error appears in the above-identified patent and that said Letters Patent is hereby corrected as shown below:

On Title Page, Column 1, Item (51), under “Int. Cl.”,  
delete “**B65D 83/38** (2006.01)  
      **B67D 7/02** (2010.01)” and  
insert --**B65D 83/38** (2006.01)--, therefor.


On Page 2, Column 1, Item (51), under “Int. Cl.”,  
delete “**B29C 49/24** (2006.01)  
      **B29C 49/58** (2006.01)  
      **B65D 23/02** (2006.01)  
      **B29D 22/00** (2006.01)  
      **B29L 31/00** (2006.01)  
      **B29C 49/06** (2006.01)  
      **B29L 9/00** (2006.01)”.

On Page 5, Column 2, Item (56), under “OTHER PUBLICATIONS”, Line 6, delete “Ophir, A. et al”  
and insert --Ophir, A. et al.--, therefor.

In the Claims

In Column 28, Claim 16, Line 28, delete “or the overpack,” and insert --of the overpack--, therefor.

Signed and Sealed this  
Tenth Day of May, 2016



Michelle K. Lee  
Director of the United States Patent and Trademark Office